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(54) Title: PHOTOTHERMOGRAPHIC ELEMENT WITH REDUCED WOODGRAIN INTERFERENCE PATTERNS		
(57) Abstract <p>The present invention provides a spectrally sensitized photothermographic silver halide element comprising a support layer having on at least one surface thereof a photothermographic composition which displays uniform image density across its surface when exposed to floodlight or uniform incandescent light exposure at radiation wavelengths to which the element is sensitive, said element comprising at least two layers, including a top layer and a photothermographic emulsion layer, said photothermographic emulsion layer comprising a binder, a light insensitive silver source, a reducing agent for silver ion and infrared radiation sensitive silver halide grains, wherein the coherent radiation is rendered more diffuse in its passage through the element than when it strikes the top layer. This may be accomplished at least in part by 1) the top layer of the element having haze induced therein of 0.05 to 30 % by surface modification of that layer, 2) there being a random refractive pattern on the top layer, 3) haze being induced in the silver halide containing layer, 4) the reflective characteristics of a surface of the support layer facing the photothermographic composition have been altered to reduce reflection of coherent radiation into said composition, and/or 5) having a radiation absorbing material contained within the photothermographic element to decrease light reflected off of the support.</p>		

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**PHOTOTHERMOGRAPHIC ELEMENT WITH REDUCED WOODGRAIN
INTERFERENCE PATTERNS**

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BACKGROUND OF THE INVENTION

Field of the Invention

This invention relates to radiation sensitized,
10 photothermographic elements composed of a silver halide
grain, a reducible silver source, a reducing agent for
silver ion, and a binder; and in particular to such
photothermographic elements having emulsion coatings
providing uniform optical density and which are free of
15 certain types of optical patterns produced by coherent
radiation imaging.

Background of the Art

The increasing availiblilty and use of semi-
conductor light sources, and particularly laser diodes
20 which emit in the visible and particularly in the red
and near infrared region of the electromagnetic
spectrum, have led to the need for photothermographic
materials for medical diagnostic and graphic arts use
that have the ability to be efficiently exposed by
25 laser imagesetters, light emitting diodes, or laser
imagers and which have the ability to form sharp images
of high resolution and sharpness. In addition,
semiconductor light sources have allowed the design of

compact automated equipment which increases the productivity of the imaging process, especially in medical diagnostic and graphic arts uses. The goal of photothermographic elements is to eliminate the use of wet processing chemicals and to provide a simpler, environmentally friendly thermal system to the customer.

Silver halide-containing, photothermographic imaging materials (i.e., heat-developable photographic elements) processed with heat, and without liquid development, have been known in the art for many years.

These materials are also known as "dry silver" compositions or emulsions and generally comprise a support having coated thereon: (a) a photosensitive material that generates silver atoms when irradiated; (b) a non-photosensitive, reducible silver source; (c) a reducing agent (i.e., a developer) for silver ion, for example that silver ion in the non-photosensitive, reducible silver source; and (d) a binder.

The photosensitive material is generally photographic silver halide which must be in catalytic proximity to the non-photosensitive, reducible silver source. Catalytic proximity requires an intimate physical association of these two materials so that when silver atoms (also known as silver specks, clusters, or nuclei) are generated by irradiation or light exposure of the photographic silver halide, those nuclei are able to catalyze the reduction of the reducible silver source. It has long been understood

that silver atoms (Ag^0) are a catalyst for the reduction of silver ions, and that the photosensitive silver halide can be placed into catalytic proximity with the non-photosensitive, reducible silver source in a number of different fashions. For example, catalytic proximity can be accomplished by partial metathesis of the reducible silver source with a halogen-containing source (see, for example, U.S. Patent No. 3,457,075); by coprecipitation of silver halide and the reducible silver source material (see, for example, U.S. Patent No. 3,839,049); and other methods that intimately associate the photosensitive, photographic silver halide and the non-photosensitive, reducible silver source.

The non-photosensitive, reducible silver source is a material that contains silver ions. Typically, the preferred non-photosensitive reducible silver source is a silver salt of a long chain aliphatic carboxylic acid having from 10 to 30 carbon atoms. The silver salt of behenic acid or mixtures of acids of similar molecular weight are generally used. Salts of other organic acids or other organic materials, such as silver imidazoles, have been proposed. U.S. Patent No. 4,260,677 discloses the use of complexes of inorganic or organic silver salts as non-photosensitive, reducible silver sources.

In both photographic and photothermographic emulsions, exposure of the photographic silver halide to light produces small clusters of silver atoms (Ag^0).

The imagewise distribution of these clusters is known in the art as a latent image. This latent image is generally not visible by ordinary means. Thus, the photosensitive emulsion must be further processed to
5 produce a visible image. This is accomplished by the reduction of silver ions which are in catalytic proximity to silver halide grains bearing the clusters of silver atoms, (i.e., the latent image).

In a photothermographic element, the reducing
10 agent for the organic silver salt, often referred to as a "developer," may be any material, preferably any organic material, that can reduce silver ion to metallic silver. At elevated temperatures, in the presence of the latent image, the non-photosensitive
15 reducible silver source (e.g., silver behenate) is reduced by the reducing agent for silver ion. This produces a negative black-and-white image of elemental silver.

While conventional photographic developers such as
20 methyl gallate, hydroquinone, substituted hydroquinones, hindered phenols, catechol, pyrogallol, ascorbic acid, and ascorbic acid derivatives are useful, they tend to result in very reactive photothermographic formulations and fog during preparation
25 and coating of photothermographic elements. As a result, hindered bisphenol reducing agents have traditionally been preferred.

As the visible image in black-and-white photothermographic elements is usually produced entirely by

elemental silver (Ag^0), one cannot readily decrease the amount of silver in the emulsion without reducing the maximum image density. However, reduction of the amount of silver is often desirable to reduce the cost of raw materials used in the emulsion and/or to enhance performance. For example, toning agents may be incorporated to improve the color of the silver image of the photothermographic element. Another method of increasing the maximum image density in photographic and photothermographic emulsions without increasing the amount of silver in the emulsion layer is by incorporating dye-forming or dye-releasing materials in the emulsion. Upon imaging, the dye-forming or dye-releasing material is oxidized, and a dye and a reduced silver image are simultaneously formed in the exposed region. In this way, a dye-enhanced black-and-white silver image can be produced.

The imaging arts have long recognized that the fields of photothermography and thermography are clearly distinct from that of photography. Photothermographic and thermographic elements significantly differ from conventional silver halide photographic elements which require wet-processing.

In photothermographic and thermographic imaging elements, a visible image is created by heat as a result of the reaction of a developer incorporated within the element. Heat is essential for development and temperatures of over 100°C are routinely required. In contrast, conventional wet-processed photographic

imaging elements require processing in aqueous processing baths to provide a visible image (e.g., developing and fixing baths) and development is usually performed at a more moderate temperature (e.g.,
5 30°-50°C).

In photothermographic elements only a small amount of silver halide is used to capture light and a different form of silver (e.g., silver behenate) is used to generate the image with heat. Thus, the silver
10 halide serves as a catalyst for the development of the non-photosensitive, reducible silver source. In contrast, conventional wet-processed black-and-white photographic elements use only one form of silver (e.g., silver halide) which, upon development, is
15 itself converted to the silver image. Additionally, photothermographic elements require an amount of silver halide per unit area that is as little as one-hundredth of that used in a conventional wet-processed silver halide.

20 Photothermographic systems employ a light-insensitive silver salt, such as silver behenate, which participates with the developer in developing the latent image. In contrast, photographic systems do not employ a light-insensitive silver salt directly in the
25 image-forming process. As a result, the image in photothermographic elements is produced primarily by reduction of the light-insensitive silver source (silver behenate) while the image in photographic

black-and-white elements is produced primarily by the silver halide.

In photothermographic and thermographic elements, all of the "chemistry" of the system is incorporated within the element itself. For example, photothermographic and thermographic elements incorporate a developer (i.e., a reducing agent for the non-photo-sensitive reducible source of silver) within the element while conventional photographic elements do not. The incorporation of the developer into photothermographic elements can lead to increased formation of "fog" upon coating of photothermographic emulsions as compared to photographic emulsions. Even in so-called instant photography, developer chemistry is physically separated from the silver halide until development is desired. Much effort has gone into the preparation and manufacture of photothermographic and thermographic elements to minimize formation of fog upon coating, storage, and post-processing aging.

Similarly, in photothermographic elements, the unexposed silver halide inherently remains after development and the element must be stabilized against further development. In contrast, the silver halide is removed from photographic elements after development to prevent further imaging (i.e., the fixing step).

In photothermographic and thermographic elements the binder is capable of wide variation and a number of binders are useful in preparing these elements. In contrast, photographic elements are limited almost

exclusively to hydrophilic colloidal binders such as gelatin.

Because photothermographic and thermographic elements require thermal processing, they pose different considerations and present distinctly different problems in manufacture and use. In addition, the effects of additives (e.g., stabilizers, antifoggants, speed enhancers, sensitizers, super-sensitizers, etc.) which are intended to have a direct effect upon the imaging process can vary depending upon whether they have been incorporated in a photothermographic or thermographic element or incorporated in a photographic element.

Distinctions between photothermographic and photographic elements are described in *Imaging Processes and Materials (Neblette's Eighth Edition)*; J. Sturge et al. Ed; Van Nostrand Reinhold: New York, 1989; Chapter 9 and in *Unconventional Imaging Processes*; E. Brinckman et al, Ed; The Focal Press: London and New York: 1978; pp. 74-75.

Light sensitive recording materials may suffer from a phenomenon known as halation which causes degradation in the quality of the recorded image. Such degradation may occur when a fraction of the imaging light which strikes the photosensitive layer is not absorbed but passes through to the film base on which the photosensitive layer is coated. A portion of the light reaching the base may be reflected back to strike the photosensitive layer from the underside. Light

thus reflected may, in some cases, contribute significantly to the total exposure of the photo-sensitive layer. Any particulate matter in the photo-sensitive element may cause light passing through the element to be scattered. Scattered light which is reflected from the film base will, on its second passage through the photosensitive layer, cause exposure over an area adjacent to the point of intended exposure. It is this effect which causes at least one form of image degradation. Photothermographic materials are prone to this form of image degradation since the photosensitive layers contain light scattering particles. The effect of light scatter on image quality is well documented and is described, for example, in T. H. James *"The Theory of the Photographic Process"*, 4th Edition, Chapter 20, Macmillan 1977.

It is common practice to incorporate a light absorbing layer within the photothermographic element.

The purpose of this layer is to absorb light that has been scattered within the various coatings and which would otherwise lead to reduced image sharpness. To be effective, the absorption of this layer must be at the same wavelengths as the sensitivity of the photo-sensitive layer.

In the case of imaging materials coated on transparent base, a light absorbing layer is frequently coated on the reverse side of the base from the photo-sensitive layer. Such a coating, known as a backside coated "antihalation layer", effectively reduces

reflection of any light which has passed through the photosensitive layer. A similar effect may be achieved by a light absorbing layer interposed between the photosensitive layer and the base. This construction, described as an "antihalation underlayer" is applicable to photosensitive coatings on transparent or non-transparent bases. A light absorbing substance may be incorporated into the photosensitive layer itself to absorb scattered light. Substances used for this purpose are known as "acutance dyes". It is also possible to improve image quality by coating a light absorbing layer above the photosensitive layer of a photographic element. Coatings of this kind, described in U.S. Patent Nos. 4,581,323 and 4,312,941, prevent multiple reflections of scattered light between the internal surfaces of a photographic element.

European Patent Application 0 377 961 and U.S. Patent No. 4,581,325 describe infrared antihalation systems for photographic and photothermographic elements incorporating polymethine and holopolar dyes respectively. Although these dyes have good infrared absorbance, they have visible absorbance that is too high for use in subsequent exposures or viewing.

Antihalation systems that would satisfy a desired requirement of an IR/visible absorbance ratio of 30 to 1 would include the thermal-dye-bleach construction described in European Patent Application 0 403 157, and in U.S. Patent Application Serial Number 08/072,153 (filed November 23, 1993).

In addition to proper antihalation, a critical step in attaining proper sensitometric properties is the addition of photosensitive silver halide. It is well known in the art that the addition of silver halide grains to a photothermographic formulation can be implemented in a number of ways but basically the silver halide is either made "ex situ" and added to the organic silver salt or made "in situ" by adding a halide salt to the organic silver salt. The addition of silver halide grains to photothermographic materials is described in *Research Disclosure*, June 1978, Item No. 17029. It is also claimed in the art that when silver halide is made ex situ one has the possibility of controlling the composition and size of the grains much more precisely so that one can impart more specific properties to the photothermographic element and can do so much more consistently than with the in situ technique.

Other performance characteristics influenced by the silver halide component that are desired for achieving a high quality photothermographic material for medical and graphic arts applications are: increased development efficiency, increased photo-speed, increased maximum density (D_{max}) and lower minimum density (D_{min}), and lower haze. U.S. Patent No. 4,435,499 claims that these characteristics are not well addressed by conventionally prepared cubic grain silver halide gelatino photographic emulsions used in ex situ formulations. In fact, they claim advantages

for tabular grains that give increased speed while maintaining a high surface area so that silver efficiency remains high. However, it is well known that tabular grains give relatively broad size
5 distributions which usually results in photosensitive materials of lower contrast than monomodal distributions.

While U.S. Patent No. 4,435,499 demonstrates increased speed and increased development efficiency,
10 it does not show that increased Dmax is attained or that Dmin and haze remain lower than if very fine conventional cubic grains are used. In fact, it is known that larger grains tend to give high levels of haze.

15 Infrared supersensitization of photographic and photothermographic materials to attain increased sensitivity is described in detail in U.S. Patent Application No. USSN 07/846,919 filed April 13, 1992.

Many different additives and modifications are
20 made in photothermographic elements to optimize the image quality of the medium. It is normally desirable, for example, to make the distribution of image forming ingredients as uniform as possible throughout the emulsion layer(s) and to make the layers uniform in
25 thickness and as smooth as possible.

When a high quality photothermographic medium is exposed by coherent radiation (e.g., laser imaging system) at a uniform exposure level across the entire surface of the sheet, a remarkably woodgrain-like

appearance is produced across the entire surface. This adverse phenomenon (termed "woodgrain") is a spurious pattern produced in the medium upon exposure to coherent radiation and bears a remarkable resemblance to the pattern of grains in wood, hence the name.

These patterns tend to be neither symmetrical nor repetitive, and like the grain in polished wood, appear as variations in optical density (lightness and darkness) on the image surface. Such spurious image patterns are of course undesirable in any imaging system where the quality of the image is critical.

It was found by the Inventors, however, that the better the coating quality and general uniformity of photothermographic elements addressed by coherent radiation, the more prominent became the "woodgrain" patterns. Additionally, the more uniform the optical density of the developed image upon floodlight or uniform incandescent light exposure the more serious seemed to be the woodgrain pattern produced in the same medium upon exposure to coherent radiation.

This type of patterning presently has been found to be unique to photothermographic imaging systems, and even multiple scanning with a beam of coherent radiation (as done on commercial equipment for wet processed silver halide media and as disclosed in U.S. Serial No. 08/198,970 filed February 18, 1994 for photothermographic elements) has shown minimum improvement with respect to this particular type of patterning in the final image.

SUMMARY OF THE INVENTION

The present invention describes elements which further enable the attainment of a high quality photo-
5 thermographic imaging system, especially those spectrally sensitized to the red or infrared, with excellent image quality, and particularly with uniform optical density characteristics and reduced levels or absence of woodgrain patterns. A further aspect is the
10 possibility of low absorbance at 380 nm to facilitate graphic arts applications such as contact printing.

According to the present invention there is provided a spectrally sensitized photothermographic silver halide element comprising a support layer having
15 on at least one surface thereof a photothermographic composition which displays uniform image density across its surface when exposed to floodlight or uniform incandescent light exposure at radiation wavelengths to which the element is sensitive, said element comprising
20 at least two layers, including a top layer and a photothermographic emulsion layer, said photothermographic emulsion layer comprising a binder, a light insensitive silver source, a reducing agent for silver ion and infrared radiation sensitive silver halide grains,
25 wherein the coherent radiation is rendered more diffuse in its passage through the element than when it strikes the top layer. This may be accomplished at least in part by 1) the top layer of the element having haze induced therein of 0.05 to 30% by surface modification

of that layer, 2) there being a random refractive pattern on the top layer, 3) haze being induced in the silver halide containing layer, 4) the reflective characteristics of a surface of the support layer facing the photothermographic composition have been altered to reduce reflection of coherent radiation into said composition, and/or 5) having a radiation absorbing material contained within the photothermographic element to decrease light reflected off of the support.

When the above element is provided with the described proper physical modifications to alter certain characteristics in the imaging radiation as it passes into and/or through the photosensitive layers, uniform optical density with reduced woodgrain effects can be produced. In other words, the mechanisms used to reduce woodgrain include: diffusing the coherent radiation at the surface of the element, randomly distorting the refraction of coherent radiation at the surface of the element, absorbing radiation within the element, and/or altering the reflection characteristics of radiation from the support carrying the photosensitive photothermographic layer(s).

The present invention also provides a process for the exposure of an ultraviolet radiation sensitive imageable medium comprising the steps of:

- a) exposing the photothermographic element to coherent radiation to which said silver

halide grains are sensitive to generate a latent image,

- b) heating said element after exposure to develop said latent image to a visible image which is free of any visually observable woodgrain pattern.
- c) positioning the element with a visible image thereon between an ultraviolet radiation energy source and a ultraviolet radiation photosensitive imageable medium, and
- d) then exposing said imageable medium to ultraviolet radiation through said visible image, absorbing ultraviolet radiation in the areas where there is a visible image and transmitting ultraviolet radiation where there is no visible image.

The present invention additionally provides a spectrally sensitized photothermographic silver halide element comprising a support layer having on at least one surface thereof a photothermographic emulsion layer which displays uniform image density across its surface when exposed to floodlight or uniform incandescent light exposure at a wavelength of radiation to which the composition is sensitive, and said element displaying less than 0.05 variation in average optical density between adjacent areas of 1 mm² when said element is uniformly exposed over its entire surface to coherent radiation to which said element is spectrally sensitive, said element including a top layer and said

photothermographic emulsion layer comprising a binder, a light insensitive silver source, a reducing agent for silver ion, and radiation sensitive silver halide grains.

5 The infrared sensitive silver halide grains may be formed *in situ* or be pre-formed, but they are preferably pre-formed.

 It is preferred that the silver halide grains have a number average grain size of less than 0.10 μm and an antihalation or acutance dye which has an infrared peak
10 absorbance (before processing) to visible absorbance (before and/or after processing) ratio of greater than or equal to 30 to 1.

 A further improvement is the incorporation of
15 supersensitizers to enhance the infrared sensitivity of the article.

 Combining these fine grains with the super-sensitizers described provides a high speed, high D_{max} , high efficiency, low D_{min} , and low haze element which
20 is useful as a coherent radiation (e.g., laser) exposed film for both graphic arts and diagnostic imaging applications.

 The reducing agent for the reducible source of silver may be a compound that can be oxidized directly
25 or indirectly to form or release a dye.

 When the photothermographic element used in this invention is heat developed, preferably at a temperature of from about 80°C to about 250°C (176°F to 482°F) for a duration of from about 1 second to about 2

minutes, in a substantially water-free condition after, or simultaneously with, imagewise exposure, an image is obtained either in exposed areas or in unexposed areas with exposed photosensitive silver halide.

5 Heating in a substantially water-free condition as used herein, means heating at a temperature of 80° to 250°C. The term "substantially water-free condition" means that the reaction system is approximately in equilibrium with water in the air, and water for
10 inducing or promoting the reaction is not particularly or positively supplied from the exterior to the element. Such a condition is described in T. H. James *The Theory of the Photographic Process*, Fourth Edition, page 374.

15 As used herein, the term "emulsion layer" means a layer of a photothermographic element that contains photosensitive silver salt (e.g., silver halide) and light-insensitive silver source material.

 As used herein the term "photothermographic
20 element" means a construction comprising at least one photothermographic emulsion layer and any supports, topcoat layers, image receiving layers, blocking layers, antihalation layers, subbing or priming layers, etc.

25 For the purposes of this invention the infrared region of the spectrum is defined as 750-1400 nm, the visible region of the spectrum is defined as 400-750 nm, and the red region of the spectrum is defined as

640-750 nm. Preferably the red region of the spectrum is 650-700 nm.

DETAILED DESCRIPTION OF THE INVENTION

5 To date, photothermographic systems have not been useful for medical diagnostic or graphic arts laser recording purposes because of slow speed, low Dmax, poor contrast and insufficient sharpness at high Dmax.

Copending U.S. Patent Applications Serial Nos.

10 08/072,153 (filed November 23, 1993) and 08/239,984 (filed May 9, 1994) describe most of the characteristics and attributes of a photothermographic element having, for example, an antihalation system, silver halide grains having an average particle size of
15 less than 0.10 μm , and infrared supersensitization leading to an infrared photothermographic article reaching the requirements for medical or graphic arts laser recording applications.

20 One of the significant causes of the woodgrain problem is the high quality and consistency and uniformity of the photosensitive coating(s) and layer(s). In the practice of the present invention, uniform coatings are those photothermographic layer(s) on a transparent support which, when uniformly imaged
25 with an incandescent light exposure at the wavelength of maximum sensitivity of the photothermographic layer(s) and uniformly thermally developed provides an image which does not vary significantly in optical density from one exposed area to another by more than

5% in optical density units at a greyout optical density of 1.8 with uniform backlighting of the imaged medium. This concept of uniformity in the coating is important to appreciate. Without the uniformity in coating quality, the image capability of the material is insufficient for medical radiographic purposes, as well as other high image quality imaging formats. However, it is attaining the modern limits of coating quality which in fact creates the very problem of woodgraining.

The most readily observable embodiment of coating quality which can be visually observed is in an image on a film base which is uniformly flooded with light from an incandescent source and observed through backlighting with white light as used on medical radiographic imaging screens. The photothermographic element is then uniformly heated (this can be done with the thermal developing system described in U.S. Patent Application Serial No. 08/239,709, filed on May 9, 1994, and U.S. Patent Application Serial No. 08/289,284. The intensity is controlled according to the sensitometry of the media to provide a "gray out," an optical density of between 1.0 and 2.0, preferably between 1.5 and 1.9, and most preferably about 1.8 uniformly over the surface. A uniform optical density is attained when the image observed through the backlit developed medium on a transparent base displays visually observable optical density variations of less than 0.1, preferably less than 0.075, more preferably less than

0.05 and still more preferably less than 0.04, and most preferably less than 0.03. It is possible to actually measure these values, but visual observation is the best critical evaluation of consistency. The degree in variation in optical densities throughout the imaged article when backlit is reasonably related to the uniformity of the coating in both thickness and composition. It is to be noted that the highest grades of commercial photothermographic film previously sold displays very high and very random variations in image density when so imaged and developed.

Although Applicants can only hypothesize as to the exact cause of the woodgrain phenomenon it appears to be caused by minute variations in the thickness of the photothermographic imaging layer(s). These presumed minute variations allow the coherent imaging radiation to form optical interference patterns which alter the effective imaging intensity of the radiation (higher or lower) in a random pattern. In essence, the minor variations in thickness (which appear to be within the order of 10-200 nm variations and display some inherent periodicity) in the total thickness of 10-40 μm thick photosensitive layer(s) appear to cause varying amounts of interference within the photosensitive layer(s).

Amongst the features of this phenomenon are the facts that the phenomenon is non-existent in incandescent exposure of the same medium at the same wavelength as that of the coherent radiation exposure, and that the effect becomes more pronounced as the

uniformity of the photosensitive layer coatings is improved. Fringe suppression in laser exposed photographic elements was taught in U.S. Patent No. 4,711,838 (Grzeskowiak and Philip). The phenomenon addressed by this patent is different from the woodgrain pattern in photothermographic elements. The woodgrain problem is unique to photothermographic elements because of the weak absorption and minimal scattering in photothermographic elements.

Four distinct modifications of the photothermographic elements in the practice of this invention have been found to be effective to reduce the woodgrain effect in the developed image: (1) Increasing haze of the top coat (the uppermost layer) and/or emulsion layer (top coat surface roughening, refractive index inhomogeneity in top coat or silver emulsion), (2) Roughening of the interface between the photosensitive layer and the support, (3) Reducing or dispersing the reflection at the emulsion-support interface, and (4) Incorporating an accutance dye in the emulsion layer.

The invention may be considered from a number of different scientific perspectives. One of those perspectives is as a spectrally sensitized photothermographic silver halide element comprising a support layer having on at least one surface thereof a photothermographic emulsion layer which displays uniform image density across its surface when exposed to floodlight or uniform incandescent light exposure at a wavelength of radiation to which the composition is

sensitive, and said element displaying less than 0.05 variation in average optical density amongst any three linearly consecutive areas defined by squares (i.e., three squares in a row forming a rectangle of dimensions 1 [square side] X 3 [square sides]) of from 0.5 mm² to 5 cm² when said element is uniformly exposed over its entire surface to coherent radiation to which said element is spectrally sensitive, said photothermographic element including a top layer and said photothermographic emulsion layer comprising a binder, a light insensitive silver source, a reducing agent for silver ion, and radiation sensitive silver halide grains. The three linearly consecutive areas are reasonably selected as squares of 1mm². The element of the invention may be further described by another perspective in which it is seen that the top layer displays a first spatial frequency of variations in a first property which alters light refraction and/or light reflection, said first property being selected from the group consisting of surface planarity (smoothness) and (uniformity of) thickness, and said element having at least one second property which alters light refraction and/or light reflection provided by at least one of said photothermographic emulsion layer, said top layer, and said support layer, said second property being a second spatial frequency of variations which is a frequency which is significantly higher (e.g., at least 25% higher), preferably at least two times higher (more preferably

at least 5 times higher and still more preferably at least 10 times higher, depending upon the actual numerical value of said first spatial frequency) than said first spatial frequency. This second property can
5 be provided at least in part by at least one feature selected from the group consisting of a) the inclusion of particulates other than silver salts of organic acids in the photothermographic emulsion layer or the top coat, b) adding acutance dyes in said
10 photothermographic emulsion layer, c) increasing haze in said photothermographic element (either in the top coat, the photothermographic emulsion layer, and/or in a primer layer), and d) providing a primer layer on said support layer which has an index of refraction
15 intermediate the index of refraction of said support layer and said photothermographic emulsion layer. The reflective properties of the base may be altered by abrasion or other disfiguring of that surface.

The optical qualities of the surface of the photothermographic element may be modified by increasing the
20 haze of the surface layer (rendering radiation which passes through the surface more diffuse within the photosensitive layers than before striking the medium).

The haze of the surface layer may be increased by
25 adding particulates into the top layer (e.g., silica, polymeric beads, etc.), preferably in a size range of 1-12 μm in average size, more preferably 1.5 to 10 μm in average size, and most preferably 2-9 μm in average size, particularly with fewer than 25% of the total

number of particulates being outside a range of $\pm 15\%$ of the average size of the particles). The particles may constitute as little as 0.5% of the surface area to have an observable effect on woodgrain reduction, and
5 may be present in amounts up to 25% of the surface area. The particulates may contribute as much as 20% to haze (or even more) while reducing woodgrain, but for other image quality considerations it is more usual to have the particles increase haze by 0.1 to 15%, more
10 preferably by 0.5 to 8%, and most preferably by 1 to 6% in reducing woodgrain. The imposition of these levels of haze in the surface layer reduces the woodgrain effect.

When woodgrain is reduced by the incorporation of
15 a plurality of optically transparent polymeric beads into at least one of the layers of the photothermographic element the composition of the polymeric beads is chosen such that substantially all of the visible wavelengths (400 nm to 700 nm) are transmitted through
20 the material to provide optical transparency. Non-limiting examples of polymeric beads that have excellent optical transparency include polymethyl methacrylate and polystyrene methacrylate beads, described in U.S. Patent No. 2,701,245; and beads
25 comprising diol dimethacrylate homopolymers or copolymers of these diol dimethacrylates with long chain fatty alcohol esters of methacrylic acid and/or ethylenically unsaturated comonomers, such as stearyl methacrylate/hexanediol diacrylate crosslinked beads,

as described in U.S. Patent No. 5,238,736 and U.S. Patent No. 5,310,595.

Even though the polymeric beads are optically transparent, haze can be introduced into the photo-thermographic elements depending upon the shape, surface characteristics, concentration, size, and size distribution of the beads. The smoothness of the bead surface and shape of the bead are chosen such that the amount of reflected visible wavelengths (400 nm to 700 nm) of light is kept to a minimum. The shape of the beads is preferably spherical, oblong, ovoid, or elliptical. The particle diameter is preferably in a size range of 1-12 μm in average size; more preferably, 1.5 to 10 μm in average size; and most preferably, 2-9 μm in average size, particularly with fewer than 25% of the total number of beads being outside a range of $\pm 15\%$ of the average size of the beads. In some elements, it is advantageous to add two distinct sets of beads with different average sizes. This allows the flexibility to balance haze with slip or separation characteristics. The beads may be present on the surface from about 50 to 500 beads/ mm^2 ; more preferably, 75 to 400 beads/ mm^2 ; and most preferably, 100 to 300 beads/ mm^2 . The increase in percent haze due to the introduction of the beads into the element is preferably at least 0.5%, and no more than 15%; more preferably at least 1% and no more than 8%; and most preferably at least 1% and no more than 6%.

The haze may also be affected by microstructuring of the surface layer (e.g., as by microembossing or texturizing of the surface). This can be done by microreplication techniques or calendaring or embosser rolls with appropriate patterns to generate the desired level of haze (e.g., greater than 0.1% up to 30%, and the preferred ranges described above). These surface modification techniques, or otherwise inducing random variations into the smoothness of the surface of the topcoat, will reduce woodgrain effects. The term 'random variations' must be considered within the context of the practice of this invention, as even the best applied coatings have an uncontrollable and inexact variation in thickness and surface characteristics. In fact, it is the high quality and reduced degree of these variations (keeping the existing variations within a tight tolerance) which is one of the reasons why the woodgrain pattern exists. The small thickness variations are large enough to create the interference patterns encountered with coherent light exposure. The woodgrain pattern caused by these variations have visible features on the order of 0.5 mm to 5 cm in size. These variations, depending on the particular quality of the coating, may be concentrated in ranges of, for example, 0.5 to 5 mm and from 1.0 mm to 5 cm. The random pattern or random variation according to the practice of the present invention causes the density variations due to interference to occur with a spatial frequency high

enough so as to be invisible with the naked eye.

Effectively this has been estimated as creating random variations in the surface layer of a uniform density photothermographic element wherein the variation have

5 dimensions of greater than 20 nm, more preferably greater than 30 nm, and still more preferably greater than 40 nm, and most preferably greater than 50, 60, or even 70 nm. These micro variations in the surface should be random, not in a clear repeating pattern. It
10 is estimated that these variations should cover at least 10%, preferably at least 15%, of the surface area of the elevated variation from planarity and should comprise at least 20% of the surface area of the top layer of the photothermographic element to provide
15 visible benefits in woodgrain reduction.

A model has been developed which seems to indicate a clear correlation between the standard deviation of the thickness of the topcoat layer and the peak-to-peak woodgrain density variation. This model is theoretic
20 in nature, but corresponds to the variation in optical woodgrain effects with variations in the thickness of the topcoat. Where the topcoat is nearly perfect, with standard deviations in thickness less than 10 nm, the peak-to-peak optical density variation in the woodgrain
25 pattern appears to be about 0.04 optical density units.

At 20 nm standard deviation, the peak-to-peak density variation is predicted at about 0.025, and at 60 nm, this value should drop to less than 0.015. The peak-to-peak density variation is also predicted to drop to

less than 0.01 for standard deviations in top coat
above about 70 nm. These estimates have been roughly
confirmed by experimental results in modifications of
the surface characteristics and thickness, at least to
5 the degree that increases in such variations tend to
diminish the woodgrain effect.

The addition of particulates in the photosensitive
layer (the silver halide containing layer) may also
cause an apparently distinct effect which is a benefit
10 against the woodgrain effect. The particles in the
silver halide layer may increase haze and, as with the
top coat layer containing particulates, disperse the
coherent radiation a sufficient degree to reduce the
woodgrain effect. When the particles are generated in
15 the silver halide layer by blending two different
resins which are not stable in a single phase (using
polyvinyl butyral, for example, as the primary binder
for the photothermographic layer(s) containing the
silver halide, such binders as polyester resins (e.g.,
20 PE 220 polyester), polyvinyl acetate, etc., separate
out of the blend as particulates dispersed within the
polyvinyl butyral phase. These *in situ* generated
particulates have been noted as tending to deposit or
contact the substrate (or primer layer on the
25 substrate) when the silver halide layer containing
these materials is deposited on the substrate. These
particulates tend to not affect the smoothness of the
surface of the top coat layer as they tend to be
significantly smaller in size than the thickness of the

silver halide containing layer and remain immersed or buried within that layer. These particulates may have an average size which appears to be on the order of 1/10 to 2/3 the dimensions of the thickness of the silver halide containing layer.

The presence of these particulates has also been noted as improving the adhesion of the silver halide containing layer to the substrate.

The particulates which alter the refractive properties of the surface layers, on the other hand, are provided in the photosensitive layers in such a manner that they tend to protrude from the surface of the top layer to cause the radiation diffusive effects.

The dimension(s) of the thickness of photosensitive layer(s) in a photothermographic element according to the present invention tend to be on the order of 10-40 μm for a single trip photosensitive element and 0.5 to 6 μm for the topcoat and 10-40 μm for the silver trip layer in a two layer photothermographic system. In the two trip construction, which is the preferred embodiment of the present invention, the particulates are applied in the topcoat composition and should generally be within the ranges indicated above for the particles (e.g., between 1 and 12 μm in number average diameter).

Alteration of the refractive characteristics of the surface may be accomplished, for example, by including particulates within the photothermographic emulsion layer (in a single trip or two trip

construction) which cause the surface of the topcoat
(or the surface of the emulsion layer in a single trip
coating) to bulge over the particles. These bulges
induce variations in both the angle at which coherent
5 imaging radiation strikes the surface of the photo-
thermographic element and causes a variation in the
distance which the radiation must travel to impact the
support layer. These randomly imposed variations are
enough to alter the pattern of light travel through the
10 photosensitive medium (and the light reflected from the
backside) to reduce or eliminate the woodgrain pattern.
Again, these internally induced random variations
preferably cover the dimensions noted above.

Modification of the internal reflection
15 characteristics of the support which should be effected
to reduce woodgrain patterns according to the present
invention include alteration of the refractive index of
the surface and altering the reflective pattern of the
support. The refractive index of the support is
20 changed by applying a coating thereto which is closer
to the refractive index of the photothermographic
layer(s) adjacent the support. This alteration reduces
the amount of radiation reflected from the support and
reduces the amounts of interference which can occur
25 between radiation paths within the photosensitive
element. The reflective pattern of the support may be
altered by changes in the smoothness characteristics of
the surface. Although it has been generally
traditional to seek the smoothest surface possible for

internal layers, it is effective in the practice of the present invention to roughen the surface of the support layer which faces the photothermographic emulsion(s) to reduce the woodgrain effect. Roughening may be

5 performed on the base prior to coating it with the photothermographic layer(s) by any available technique, including but not limited to abrasion, chemical etching, sputter etching, ablation (e.g., by laser, flash lamp, ion diode, coaxial plasma accelerator, ion

10 accelerator, etc.), non-ablative high energy treatments such as quasi-amorphization (e.g., see U.S. Patent Nos. 4,879,176 and 4,822,451), and the like. It is desirable to apply these processes to the support to reduce reflection at the wavelength of the imaging

15 coherent radiation by at least 0.5% up to 50% or even 100% (being totally transparent or totally absorptive of the exposing radiation, e.g., infrared radiation, while being transmissive of visible radiation), more reasonably between 2 and 25%. It has also been noted

20 that certain applications of these high energy surface treatments do not ablate the surface yet improve woodgrain resistance. It has been suggested by the inventors that high energy, non-ablative treatment of the surface may be changing the refractive index of the

25 surface without ablating material. This could be the result of crystalline morphologic changes in the surface (as in quasi-amorphization of semicrystalline or polyimide materials) which change in crystalline

state is displayed at least in part by a change in the index of refraction.

Another technique to effectively roughen the surface of the support is to apply a coating of optically roughening material prior to coating the layers of the photothermographic element.

Antihalation and Acutance Materials

Photothermographic elements according to the present invention can contain antihalation and acutance, 5,266,452, and 5,314,795. If desired, the dyes can be mordanted, for example, as described in U.S. Patent No. 3,282,699.

Infrared antihalation systems that satisfy the requirement of an IR/visible absorbance ratio of 30 to 1 after processing are the thermal-dye-bleach constructions described in U.S. Patent No. 5,314,795 and in U.S. Patent Application Serial Number 08/072,153 (filed November 23, 1993).

Another infrared antihalation system that satisfies the requirement of an IR/visible absorbance ratio of 30 to 1 after processing would be the thermal-dye-bleach construction described in U.S. Patent Nos. 5,135,842 and 5,266,452. For example, dyes, D-9 and D-10 of the above U.S. Patents, when used in the thermal-dye-bleach formulation do not have a 30 to 1 ratio of IR/visible absorbance before heat processing. Only after thermal bleaching does the system satisfy the 30 to 1 ratio.

An infrared antihalation system that satisfies the requirement of an IR/visible absorbance ratio of 30 to 1 before and after processing can be achieved with non-bleaching indolenine dyes.

5 Useful dyes were shown in U.S. Patent Application Serial No. 07/846,919 to be a weak infrared sensitizer in photothermographic systems. However, the minimum amount of dye of those formulae for use for acutance purposes greatly exceeds the maximum amount of dye used
10 for sensitizing purposes. For example, the quantity of sensitizing dye used in the photothermographic emulsion disclosed in U.S. Patent Application Serial No. 07/846,919 was 3.1 mg/meter² whereas for acutance purposes in accordance with the invention the dyes
15 would generally be used at a higher level.

 Although many of the dyes described above are heptamethine dyes, it is also anticipated that similar nonamethine dyes would be suitable for use as acutance and antihalation dyes.

20 The dyes are generally added to the photothermographic element in a sufficient amount to provide a transmission optical density of greater than 0.1 at λ_{max} of the dye. Generally, the coating weight of the dye which will provide the desired effect is from 5 to
25 200 mg/meter², more preferably as 10 to 150 mg/meter². For purposes of good viewing of the imaged and developed film, or for exposing through the imaged-developed film it is desirable to for the dye to have a

visible absorbance less of ≤ 0.01 or to be bleached to a material having a visible absorbance of ≤ 0.01).

The dyes may be incorporated into photothermographic elements as acutance dyes according to conventional techniques. The dyes may also be incorporated into antihalation layers according to techniques of the prior art as an antihalation backing layer, an antihalation underlayer or as an overcoat.

The Photosensitive Silver Halide

As noted above, the present invention includes a photosensitive silver halide in the photothermographic element. The photosensitive silver halide can be any photosensitive silver halide, such as silver bromide, silver iodide, silver chloride, silver bromiodide, silver chlorobromiodide, silver chlorobromide, etc. The photosensitive silver halide can be added to the emulsion layer in any fashion so long as it is placed in catalytic proximity to the organic silver compound which serves as a source of reducible silver.

The silver halide may be in any form which is photosensitive including, but not limited to cubic, octahedral, rhombic dodecahedral, orthorhombic, tetrahedral, other polyhedral habits, etc., and may have epitaxial growth of crystals thereon. Tabular grains are not preferred and are in fact least preferred crystal habits to be used in the photothermographic elements of the present invention. Narrow grain size distributions of truly tabular grains (e.g., with aspect ratios of 5:1 and greater) can not be readily

provided by existing techniques with the preferred grain sizes of less than an average diameter size of 0.10 μm .

There are grains referred to in the art as "tabular," "laminar," or "sigma" grains which may have aspect ratios of less than 5:1, such as disclosed in U.S. Patent No. 4,806,461 which shows "tabular" twinned plane grains called laminar grains with aspect ratios equal to or greater than 2:1 with grain thickness of less than 0.5 μm and grain diameter averages of less than 0.3, but it is not clear that such grains are within the consideration of the ordinarily skilled artisan as laminar or tabular grains as much as they are merely definitions broadening the coverage of the terms without the conceptual benefits of the original disclosures of tabular grains in providing higher capture surface areas to volume ratios for the silver halide grains (e.g., higher projected areas per coating weight of grains as in U.S. Patent Nos. 4,425,425 and 4,425,426).

The silver halide grains may have a uniform ratio of halide throughout; they may have a graded halide content, with a continuously varying ratio of, for example, silver bromide and silver iodide; or they may be of the core-shell-type, having a discrete core of one halide ratio, and a discrete shell of another halide ratio. Core-shell type silver halide grains useful in photothermographic elements and methods of preparing these materials are described in allowed copending U.S. Patent Application Serial Number

08/199,114 (filed February 22, 1994). A core-shell silver halide grain having an iridium doped core is particularly preferred. Iridium doped core-shell grains of this type are described in copending U.S. Patent Application Serial number 08/239,984 (filed May 9, 1994).

The silver halide may be prepared *ex situ*, (i.e., be pre-formed) and mixed with the organic silver salt in a binder prior to use to prepare a coating solution.

The silver halide may be pre-formed by any means, e.g., in accordance with U.S. Patent No. 3,839,049. For example, it is effective to blend the silver halide and organic silver salt using a homogenizer for a long period of time. Materials of this type are often referred to as "pre-formed emulsions." Methods of preparing these silver halide and organic silver salts and manners of blending them are described in *Research Disclosure*, June 1978, item 17029; U.S. Patent Nos. 3,700,458 and 4,076,539; and Japanese patent application Nos. 13224/74, 42529/76, and 17216/75.

It is desirable in the practice of this invention to use pre-formed silver halide grains of less than 0.10 μm in an infrared sensitized, photothermographic material. Preferably the number average particle size of the grains is between 0.01 and 0.08 μm ; more preferably, between 0.03 and 0.07 μm ; and most preferably, between 0.04 and 0.06 μm . It is also preferred to use iridium doped silver halide grains and iridium doped core-shell silver halide grains as

disclosed in copending U.S. Patent Application Serial Nos. 08/072,153, and 08/239,984 described above.

Pre-formed silver halide emulsions when used in the material of this invention can be unwashed or
5 washed to remove soluble salts. In the latter case the soluble salts can be removed by chill-setting and leaching or the emulsion can be coagulation washed, e.g., by the procedures described in U.S. Patent Nos. 2,618,556; 2,614,928; 2,565,418; 3,241,969; and
10 2,489,341.

It is also effective to use an *in situ* process, i.e., a process in which a halogen-containing compound is added to an organic silver salt to partially convert the silver of the organic silver salt to silver halide.

15 The light sensitive silver halide used in the present invention can be employed in a range of about 0.005 mole to about 0.5 mole; preferably, from about 0.01 mole to about 0.15 mole per mole; and more preferably, from 0.03 mole to 0.12 mole per mole of
20 non-photosensitive reducible silver salt.

The silver halide used in the present invention may be chemically and spectrally sensitized in a manner similar to that used to sensitize conventional wet process silver halide or state-of-the-art heat-
25 developable photographic materials. For example, it may be chemically sensitized with a chemical sensitizing agent, such as a compound containing sulfur, selenium, tellurium, etc., or a compound containing gold, platinum, palladium, ruthenium,

rhodium, iridium, etc., a reducing agent such as a tin halide, etc., or a combination thereof. The details of these procedures are described in T.H. James *The Theory of the Photographic Process*, Fourth Edition, Chapter 5, pages 149 to 169. Suitable chemical sensitization procedures are also described in Shepard, U.S. Patent No. 1,623,499; Waller, U.S. Patent No. 2,399,083; McVeigh, U.S. Patent No. 3,297,447; and Dunn, U.S. Patent No. 3,297,446.

Addition of sensitizing dyes to the photosensitive silver halides serves to provide them with high sensitivity to visible and infrared light by spectral sensitization. Thus, the photosensitive silver halides may be spectrally sensitized with various known dyes that spectrally sensitize silver halide. Non-limiting examples of sensitizing dyes that can be employed include cyanine dyes, merocyanine dyes, complex cyanine dyes, complex merocyanine dyes, holopolar cyanine dyes, hemicyanine dyes, styryl dyes, and hemioxanol dyes. Of these dyes, cyanine dyes, merocyanine dyes, and complex merocyanine dyes are particularly useful.

An appropriate amount of sensitizing dye added is generally about 10^{-10} to 10^{-1} mole; and preferably, about 10^{-8} to 10^{-3} moles per mole of silver halide.

Supersensitizers

To get the speed of the photothermographic elements up to maximum levels and further enhance infrared sensitivity, it is often desirable to use supersensitizers. Any supersensitizer could be used which increases the infrared sensitivity, but the preferred supersensitizers are described in copending U.S. Patent Application Serial No. 07/846,919 and include heteroaromatic mercapto compounds (I) or heteroaromatic disulfide compounds (II)



wherein M represents a hydrogen atom or an alkali metal atom.

In supersensitizers (I) and (II), Ar represents an aromatic ring or fused aromatic ring containing one or more of nitrogen, sulfur, oxygen, selenium or tellurium atoms. Preferably, the heteroaromatic ring is benzimidazole, naphthimidazole, benzothiazole, naphthothiazole, benzoxazole, naphthoxazole, benzoselenazole, benzotellurazole, imidazole, oxazole, pyrazole, triazole, thiadiazole, tetrazole, triazine, pyrimidine, pyridazine, pyrazine, pyridine, purine, quinoline or quinazolinone. However, other heteroaromatic rings are envisioned under the breadth of this invention.

The heteroaromatic ring may also carry substituents with examples of preferred substituents being selected from the class consisting of halogen (e.g., Br and Cl), hydroxy, amino, carboxy, alkyl (e.g.

of 1 or more carbon atoms, preferably 1 to 4 carbon atoms) and alkoxy (e.g. of 1 or more carbon atoms, preferably of 1 to 4 carbon atoms).

The preferred supersensitizers are 2-mercaptobenzimidazole, 2-mercapto-5-methylbenzimidazole and
5 2-mercaptobenzothiazole.

The supersensitizers are used in general amount of at least 0.001 moles/mole of silver in the emulsion layer. Usually the range is between 0.001 and 1.0
10 moles of the compound per mole of silver and preferably between 0.01 and 0.3 moles of compound per mole of silver.

The Non-Photosensitive Reducible Silver Source Material

The non-photosensitive reducible silver source
15 that can be used in the present invention can be any material that contains a source of reducible silver ions. Preferably, it is a silver salt which is comparatively stable to light and forms a silver image when heated to 80°C or higher in the presence of an
20 exposed photocatalyst (such as silver halide) and a reducing agent.

Silver salts of organic acids, particularly silver salts of long chain fatty carboxylic acids, are preferred. The chains typically contain 10 to 30,
25 preferably 15 to 28, carbon atoms. Suitable organic silver salts include silver salts of organic compounds having a carboxyl group. Examples thereof include a silver salt of an aliphatic carboxylic acid and a silver salt of an aromatic carboxylic acid. Preferred

examples of the silver salts of aliphatic carboxylic acids include silver behenate, silver stearate, silver oleate, silver laureate, silver caprate, silver myristate, silver palmitate, silver maleate, silver fumarate, silver tartarate, silver furoate, silver linoleate, silver butyrate, silver camphorate, and mixtures thereof, etc. Silver salts that can be substituted with a halogen atom or a hydroxyl group also can be effectively used. Preferred examples of the silver salts of aromatic carboxylic acid and other carboxyl group-containing compounds include: silver benzoate, a silver-substituted benzoate, such as silver 3,5-dihydroxybenzoate, silver o-methylbenzoate, silver m-methylbenzoate, silver p-methylbenzoate, silver 2,4-dichlorobenzoate, silver acetamidobenzoate, silver p-phenylbenzoate, etc.; silver gallate; silver tannate; silver phthalate; silver terephthalate; silver salicylate; silver phenylacetate; silver pyromellilate; a silver salt of 3-carboxymethyl-4-methyl-4-thiazoline-2-thione or the like as described in U.S. Patent No. 3,785,830; and a silver salt of an aliphatic carboxylic acid containing a thioether group as described in U.S. Patent No. 3,330,663.

Silver salts of compounds containing mercapto or thione groups and derivatives thereof can also be used.

Preferred examples of these compounds include: a silver salt of 3-mercapto-4-phenyl-1,2,4-triazole; a silver salt of 2-mercaptobenzimidazole; a silver salt of 2-mercapto-5-aminothiadiaazole; a silver salt of

2-(2-ethylglycolamido)benzothiazole; a silver salt of thioglycolic acid, such as a silver salt of a S-alkyl-thioglycolic acid (wherein the alkyl group has from 12 to 22 carbon atoms); a silver salt of a dithio-
5 carboxylic acid such as a silver salt of dithioacetic acid; a silver salt of thioamide; a silver salt of 5-carboxylic-1-methyl-2-phenyl-4-thiopyridine; a silver salt of mercaptotriazine; a silver salt of 2-mercapto-benzoxazole; a silver salt as described in U.S. Patent
10 No. 4,123,274, for example, a silver salt of a 1,2,4-mercaptothiazole derivative, such as a silver salt of 3-amino-5-benzylthio-1,2,4-thiazole; and a silver salt of a thione compound, such as a silver salt of 3-(2-carboxyethyl)-4-methyl-4-thiazoline-2-thione as
15 disclosed in U.S. Patent No. 3,201,678. Silver salts of acetylenes can also be used. Silver acetylides are described in U.S. Patent Nos. 4,761,361 and 4,775,613.

Furthermore, a silver salt of a compound containing an imino group can be used. Preferred
20 examples of these compounds include: silver salts of benzotriazole and substituted derivatives thereof, for example silver methylbenzotriazole and silver 5-chlorobenzotriazole, etc.; silver salts of 1,2,4-triazoles or 1-H-tetrazoles as described in U.S.
25 Patent No. 4,220,709; and silver salts of imidazoles and imidazole derivatives.

It is also found convenient to use silver half soaps. A preferred example of a silver half soap is an equimolar blend of silver behenate and behenic acid,

which analyzes for about 14.5% silver and which is prepared by precipitation from an aqueous solution of the sodium salt of commercial behenic acid.

5 Transparent sheet materials made on transparent film backing require a transparent coating. For this purpose a silver behenate full soap, containing not more than about 4 or 5 percent of free behenic acid and analyzing about 25.2 percent silver, can be used.

10 The method used for making silver soap dispersions is well known in the art and is disclosed in *Research Disclosure*, April 1983, item 22812, *Research Disclosure*, October 1983, item 23419, and U.S. Patent No. 3,985,565.

15 The silver halide and the non-photosensitive reducible silver source material that form a starting point of development should be in catalytic proximity, i.e., reactive association. By "catalytic proximity" or "reactive association" is meant that they should be in the same layer, in adjacent layers, or in layers
20 separated from each other by an intermediate layer having a thickness of less than 1 micrometer (1 μ m). It is preferred that the silver halide and the non-photosensitive reducible silver source material be present in the same layer.

25 Photothermographic emulsions containing pre-formed silver halide in accordance with this invention can be sensitized with chemical sensitizers, or with spectral sensitizers as described above.

The source of reducible silver material generally constitutes about 5 to about 70 percent by weight of the emulsion layer. It is preferably present at a level of about 10 to about 50 percent by weight of the emulsion layer.

The Reducing Agent for the Non-Photosensitive Reducible Silver Source

When used in black-and-white photothermographic elements, the reducing agent for the organic silver salt may be any material, preferably organic material, that can reduce silver ion to metallic silver.

Conventional photographic developers such as phenidone, hydroquinones, and catechol are useful, but hindered bisphenol reducing agents are preferred.

When the photothermographic element used in this invention containing a reducing agent for the non-photosensitive reducible silver source is heat developed, preferably at a temperature of from about 80°C to about 250°C (176°F to 482°F) for a duration of from about 1 second to about 2 minutes, in a substantially water-free condition after, or simultaneously with, imagewise exposure, a black-and-white silver image is obtained either in exposed areas or in unexposed areas with exposed photosensitive silver halide.

A wide range of reducing agents has been disclosed in dry silver systems including amidoximes, such as phenylamidoxime, 2-thienylamidoxime and *p*-phenoxy-phenylamidoxime; azines, such as 4-hydroxy-

3,5-dimethoxybenzaldehydeazine; a combination of aliphatic carboxylic acid aryl hydrazides and ascorbic acid, such as 2,2'-bis(hydroxymethyl)propionyl-
β-phenylhydrazide in combination with ascorbic acid; a
5 combination of polyhydroxybenzene and hydroxylamine; a reductone and/or a hydrazine, such as a combination of hydroquinone and bis(ethoxyethyl)hydroxylamine, piperidinohexose reductone, or formyl-4-methylphenylhydrazine; hydroxamic acids, such as phenylhydroxamic
10 acid, *p*-hydroxyphenylhydroxamic acid, and *o*-alaninehydroxamic acid; a combination of azines and sulfonamidophenols, such as phenothiazine with *p*-benzenesulfonamidophenol or 2,6-dichloro-4-benzenesulfonamidophenol; α-cyanophenylacetic acid
15 derivatives, such as ethyl α-cyano-2-methylphenylacetate, ethyl α-cyano-phenylacetate; bis-*o*-naphthols, such as by 2,2'-dihydroxyl-1-binaphthyl, 6,6'-dibromo-2,2'-dihydroxy-1,1'-binaphthyl, and bis(2-hydroxy-1-naphthyl)methane; a combination of bis-*o*-naphthol and
20 a 1,3-dihydroxybenzene derivative, such as 2,4-dihydroxybenzophenone or 2,4-dihydroxyacetophenone; 5-pyrazolones such as 3-methyl-1-phenyl-5-pyrazolone; reductones, such as dimethylaminohexose reductone, anhydrodihydroaminohexose reductone, and anhydro-
25 dihydro-piperidone-hexose reductone; sulfonamidophenol reducing agents, such as 2,6-dichloro-4-benzenesulfonamidophenol and *p*-benzenesulfonamidophenol; indane-1,3-diones, such as 2-phenylindane-1,3-dione; chromans, such as 2,2-dimethyl-7-*t*-butyl-6-hydroxy-

chroman; 1,4-dihydropyridines, such as 2,6-dimethoxy-3,5-dicarbethoxy-1,4-dihydropyridine; bisphenols, such as bis(2-hydroxy-3-*t*-butyl-5-methylphenyl)methane, 1,1-bis(2-hydroxy-3,5-dimethylphenyl)-3,5,5-trimethyl-
5 hexane, 2,2-bis(4-hydroxy-3-methylphenyl)propane, 4,4-ethylidene-bis(2-*t*-butyl-6-methylphenol), and 2,2-bis(3,5-dimethyl-4-hydroxyphenyl)propane; ascorbic acid derivatives, such as 1-ascorbylpalmitate, ascorbylstearate; unsaturated aldehydes and ketones;
10 certain 1,3-indanediones, and 3-pyrazolidones (phenidones).

The reducing agent should be present as 1 to 10% by weight of the imaging layer. In multilayer elements, if the reducing agent is added to a layer
15 other than an emulsion layer, slightly higher proportions, of from about 2 to 15%, tend to be more desirable.

The Optional Dye-Forming or Dye-Releasing Material

As noted above, the reducing agent for the
20 reducible source of silver may be a compound that can be oxidized directly or indirectly to form or release a dye.

When the photothermographic element used in this invention containing an optional dye-forming or dye-releasing material is heat developed, preferably at a
25 temperature of from about 80°C to about 250°C (176°F to 482°F) for a duration of from about 1 second to about 2 minutes, in a substantially water-free condition after, or simultaneously with, imagewise exposure, a dye image

is obtained simultaneously with the formation of a silver image either in exposed areas or in unexposed areas.

Leuco dyes are one class of dye-forming material that form a dye upon oxidation. Any leuco dye capable of being oxidized by silver ion to form a visible image can be used in the present invention. Leuco dyes that are both pH sensitive and oxidizable can also be used, but are not preferred. Leuco dyes that are sensitive only to changes in pH are not included within scope of dyes useful in this invention because they are not oxidizable to a colored form.

As used herein, a "leuco dye" or "blocked leuco dye" is the reduced form of a dye that is generally colorless or very lightly colored and is capable of forming a colored image upon oxidation of the leuco or blocked leuco dye to the dye form. Thus, the blocked leuco dyes (i.e., blocked dye-releasing compounds), absorb less strongly in the visible region of the electromagnetic spectrum than do the dyes. The resultant dye produces an image either directly on the sheet on which the dye is formed or, when used with a dye- or image-receiving layer, on the image-receiving layer upon diffusion through emulsion layers and interlayers.

Representative classes of leuco dyes that can be used in the photothermographic elements of the present invention include, but are not limited to: chromogenic leuco dyes, such as indoaniline, indophenol, or

azomethine leuco dyes; imidazole leuco dyes, such as
2-(3,5-di-t-butyl-4-hydroxyphenyl)-4,5-diphenyl-
imidazole, as described in U.S. Patent No. 3,985,565;
dyes having an azine, diazine, oxazine, or thiazine
5 nucleus such as those described in U.S. Patent Nos.
4,563,415; 4,622,395; 4,710,570; and 4,782,010; and
benzylidene leuco compounds as described in U.S. Patent
No. 4,923,792.

Another preferred class of leuco dyes useful in
10 this invention are those derived from azomethine leuco
dyes or indoaniline leuco dyes. These are often
referred to herein as "chromogenic leuco dyes" because
many of these dyes are useful in conventional, wet-
processed photography. Chromogenic dyes are prepared
15 by oxidative coupling of a *p*-phenylenediamine compound
or a *p*-aminophenol compound with a photographic-type
coupler. Reduction of the corresponding dye as
described, for example, in U.S. Patent No. 4,374,921
forms the chromogenic leuco dye. Leuco chromogenic
20 dyes are also described in U.S. Patent No. 4,594,307.
Cyan leuco chromogenic dyes having short chain
carbamoyl protecting groups are described in European
Laid Open Patent Application No. 533,008. For a review
of chromogenic leuco dyes, see K. Venkataraman, *The*
25 *Chemistry of Synthetic Dyes*, Academic Press: New York,
1952; Vol. 4, Chapter VI.

Another class of leuco dyes useful in this
invention are "aldazine" and "ketazine" leuco dyes.
Dyes of this type are described in U.S. Patent Nos.

4,587,211 and 4,795,697. Benzylidene leuco dyes are also useful in this invention. Dyes of this type are described in U.S. Patent No. 4,923,792.

5 Yet another class of dye-releasing materials that form a diffusible dye upon oxidation are known as pre-formed-dye-release (PDR) or redox-dye-release (RDR) materials. In these materials, the reducing agent for the organic silver compound releases a mobile pre-formed dye upon oxidation. Examples of these materials
10 are disclosed in Swain, U.S. Patent No. 4,981,775.

Further, as other image-forming materials, materials where the mobility of the compound having a dye part changes as a result of an oxidation-reduction reaction with silver halide, or an organic silver salt
15 at high temperature can be used, as described in Japanese Patent Application No. 165,054/84.

Still further the reducing agent may be a compound that releases a conventional photographic dye coupler or developer on oxidation as is known in the art.

20 The dyes formed or released in the various color-forming layers should, of course, be different. A difference of at least 60 nm in reflective maximum absorbance is preferred. More preferably, the absorbance maximum of dyes formed or released will
25 differ by at least 80-100 nm. When three dyes are to be formed, two should preferably differ by at least these minimums, and the third should preferably differ from at least one of the other dyes by at least 150 nm, and more preferably, by at least 200 nm. Any reducing

agent capable of being oxidized by silver ion to form or release a visible dye is useful in the present invention as previously noted.

5 The total amount of optional leuco dye used as a reducing agent used in the present invention should preferably be in the range of 0.5-25 weight percent, and more preferably, in the range of 1-10 weight percent, based upon the total weight of each individual layer in which the reducing agent is employed.

10 The Binder

The photosensitive silver halide, the non-photo-sensitive reducible source of silver, the reducing agent, and any other addenda used in the present invention are generally added to at least one binder.

15 The binder(s) that can be used in the present invention can be employed individually or in combination with one another. It is preferred that the binder be selected from polymeric materials, such as, for example, natural and synthetic resins that are sufficiently polar to hold the other ingredients in
20 solution or suspension.

A typical hydrophilic binder is a transparent or translucent hydrophilic colloid. Examples of hydrophilic binders include: a natural substance, for
25 example, a protein such as gelatin, a gelatin derivative, a cellulose derivative, etc.; a polysaccharide such as starch, gum arabic, pullulan, dextrin, etc.; and a synthetic polymer, for example, a water-soluble polyvinyl compound such as polyvinyl

alcohol, polyvinyl pyrrolidone, acrylamide polymer, etc. Another example of a hydrophilic binder is a dispersed vinyl compound in latex form which is used for the purpose of increasing dimensional stability of a photographic element.

Examples of typical hydrophobic binders are polyvinyl acetals, polyvinyl chloride, polyvinyl acetate, cellulose acetate, polyolefins, polyesters, polystyrene, polyacrylonitrile, polycarbonates, methacrylate copolymers, maleic anhydride ester copolymers, butadiene-styrene copolymers, and the like.

Copolymers, e.g., terpolymers, are also included in the definition of polymers. The polyvinyl acetals, such as polyvinyl butyral and polyvinyl formal, and vinyl copolymers such as polyvinyl acetate and poly(vinyl chloride are particularly preferred.

Although the binder can be hydrophilic or hydrophobic, preferably it is hydrophobic in the silver containing layer(s). Optionally, these polymers may be used in combination of two or more thereof.

The binders are preferably used at a level of about 30-90 percent by weight of the emulsion layer, and more preferably at a level of about 45-85 percent by weight. Where the proportions and activities of the reducing agent for the non-photosensitive reducible source of silver require a particular developing time and temperature, the binder should be able to withstand those conditions. Generally, it is preferred that the binder not decompose or lose its structural integrity

at 250°F (121°C) for 60 seconds, and more preferred that it not decompose or lose its structural integrity at 350°F (177°C) for 60 seconds.

The polymer binder is used in an amount sufficient to carry the components dispersed therein, that is, within the effective range of the action as the binder.

The effective range can be appropriately determined by one skilled in the art.

Photothermographic Formulations

The formulation for the photothermographic emulsion layer can be prepared by dissolving and dispersing the binder, the photosensitive silver halide, the non-photosensitive reducible source of silver, the reducing agent for the non-photosensitive reducible silver source, and optional additives, in an inert organic solvent, such as, for example, toluene, 2-butanone, or tetrahydrofuran.

The use of "toners" or derivatives thereof which improve the image, is highly desirable, but is not essential to the element. Toners can be present in an amount of about 0.01-10 percent by weight of the emulsion layer, preferably about 0.1-10 percent by weight. Toners are well known materials in the photothermographic art, as shown in U.S. Patent Nos.

3,080,254; 3,847,612; and 4,123,282.

Examples of toners include: phthalimide and N-hydroxyphthalimide; cyclic imides, such as succinimide, pyrazoline-5-ones, quinazolinone, 1-phenylurazole, 3-phenyl-2-pyrazoline-5-one, and

2,4-thiazolidinedione; naphthalimides, such as
N-hydroxy-1,8-naphthalimide; cobalt complexes, such as
cobaltic hexamine trifluoroacetate; mercaptans such as
3-mercapto-1,2,4-triazole, 2,4-dimercaptopyrimidine,
5 3-mercapto-4,5-diphenyl-1,2,4-triazole and
2,5-dimercapto-1,3,4-thiadiazole; N-(aminomethyl)aryl-
dicarboximides, such as (N,N-dimethylaminomethyl)-
phthalimide, and N-(dimethylaminomethyl)naphthalene-
2,3-dicarboximide; a combination of blocked pyrazoles,
10 isothiuronium derivatives, and certain photobleach
agents, such as a combination of N,N'-hexamethylene-
bis(1-carbamoyl-3,5-dimethylpyrazole), 1,8-(3,6-diaza-
octane)bis(isothiuronium)trifluoroacetate, and
2-(tribromomethylsulfonyl benzothiazole); merocyanine
15 dyes such as 3-ethyl-5-[(3-ethyl-2-benzo-
thiazolinylidene)-1-methyl-ethylidene]-2-thio-
2,4-o-azolidinedione; phthalazinone, phthalazinone
derivatives, or metal salts or these derivatives, such
as 4-(1-naphthyl)phthalazinone, 6-chlorophthalazinone,
20 5,7-dimethoxyphthalazinone, and 2,3-dihydro-
1,4-phthalazinedione; a combination of phthalazine plus
one or more phthalic acid derivatives, such as
phthalic acid, 4-methylphthalic acid, 4-nitrophthalic
acid, and tetrachlorophthalic anhydride,
25 quinazolinediones, benzoxazine or naphthoxazine
derivatives; rhodium complexes functioning not only as
tone modifiers but also as sources of halide ion for
silver halide formation *in situ*, such as ammonium hexa-
chlororhodate (III), rhodium bromide, rhodium nitrate,

and potassium hexachlororhodate (III); inorganic peroxides and persulfates, such as ammonium peroxydisulfate and hydrogen peroxide; benzoxazine-2,4-diones, such as 1,3-benzoxazine-2,4-dione, 8-methyl-1,3-benzoxazine-2,4-dione, and 6-nitro-1,3-benzoxazine-2,4-dione; pyrimidines and asym-triazines, such as 2,4-dihydroxypyrimidine, 2-hydroxy-4-aminopyrimidine, and azauracil; and tetrazapentalene derivatives, such as 3,6-dimercapto-1,4-diphenyl-1H,4H-2,3a,5,6a-tetraazapentalene and 1,4-di-(o-chloro-phenyl)-3,6-dimercapto-1H,4H-2,3a,5,6a-tetra-azapentalene.

The photothermographic elements used in this invention can be further protected against the additional production of fog and can be stabilized against loss of sensitivity during storage. While not necessary for the practice of the invention, it may be advantageous to add mercury (II) salts to the emulsion layer(s) as an antifoggant. Preferred mercury (II) salts for this purpose are mercuric acetate and mercuric bromide.

Other suitable antifoggants and stabilizers, which can be used alone or in combination, include the thiazolium salts described in U.S. Patent Nos. 2,131,038 and U.S. Patent No. 2,694,716; the azaindenes described in U.S. Patent Nos. 2,886,437; the triazaindolizines described in U.S. Patent No. 2,444,605; the mercury salts described in U.S. Patent No. 2,728,663; the urazoles described in U.S. Patent

No. 3,287,135; the sulfocatechols described in U.S. Patent No. 3,235,652; the oximes described in British Patent No. 623,448; the polyvalent metal salts described in U.S. Patent No. 2,839,405; the thiuronium salts described in U.S. Patent No. 3,220,839; and palladium, platinum and gold salts described in U.S. Patent Nos. 2,566,263 and 2,597,915.

Photothermographic elements of the invention can contain plasticizers and lubricants such as polyalcohols and diols of the type described in U.S. Patent No. 2,960,404; fatty acids or esters, such as those described in U.S. Patent Nos. 2,588,765 and 3,121,060; and silicone resins, such as those described in British Patent No. 955,061.

The photothermographic elements of the present invention can also include image dye stabilizers. Such image dye stabilizers are illustrated by U.K. Patent No. 1,326,889; and U.S. Patent Nos. 3,432,300; 3,698,909; 3,574,627; 3,573,050; 3,764,337; and 4,042,394.

In addition to the particulates used in the present invention for optical effects, the photothermographic elements according to the present invention can also contain matting agents such as starch, titanium dioxide, zinc oxide, silica, and polymeric beads including beads of the type described in U.S. Patent Nos. 2,992,101 and 2,701,245. The beads added to the top layer in the practice of the present invention perform a dual effect in this regard.

Furthermore they can also contain antistatic or conducting layers, such as layers that comprise soluble salts, e.g., chlorides, nitrates, etc., evaporated metal layers, ionic polymers such as those described in U.S. Patent Nos. 2,861,056 and 3,206,312 or insoluble inorganic salts such as those described in U.S. Patent No. 3,428,451.

Photothermographic Constructions

The photothermographic elements of this invention can be constructed of one or more layers on a support.

Single layer constructions should contain the silver halide, the non-photosensitive, reducible silver source material, the reducing agent for the non-photosensitive reducible silver source, the binder as well as optional materials such as toners, dye-forming or dye-releasing materials, coating aids, and other adjuvants.

Two-layer constructions should contain silver halide and non-photosensitive, reducible silver source in one emulsion layer (usually the layer adjacent to the support) and some of the other ingredients in the second layer or both layers, although two layer constructions comprising a single emulsion layer coating containing all the ingredients and a protective topcoat are envisioned. Multicolor photothermographic dry silver elements can contain sets of these bilayers for each color or they can contain all ingredients within a single layer, as described in U.S. Patent No. 4,708,928. In the case of multilayer, multicolor photothermographic elements, the various emulsion

layers are generally maintained distinct from each other by the use of functional or non-functional barrier layers between the various photosensitive layers, as described in U.S. Patent No. 4,460,681.

5 Barrier layers, preferably comprising a polymeric material, can also be present in the photothermographic element of the present invention. Polymers for the material of the barrier layer can be selected from natural and synthetic polymers such as gelatin, poly-
10 vinyl alcohols, polyacrylic acids, sulfonated polystyrene, and the like. The polymers can optionally be blended with barrier aids such as silica.

Photothermographic emulsions used in this invention can be coated by various coating procedures
15 including wire wound rod coating, dip coating, air knife coating, curtain coating, or extrusion coating using hoppers of the type described in U.S. Patent No. 2,681,294. If desired, two or more layers can be coated simultaneously by the procedures described in
20 U.S. Patent No. 2,761,791 and British Patent No. 837,095. Typical wet thickness of the emulsion layer can be about 10-150 micrometers (μm), and the layer can be dried in forced air at a temperature of about
25 20-100°C. It is preferred that the thickness of the layer be selected to provide maximum image densities greater than 0.2, and, more preferably, in the range 0.5 to 4.5, as measured by a MacBeth Color Densitometer Model TD 504 using the color filter complementary to the dye color.

Additionally, it may be desirable in some instances to coat different emulsion layers on both sides of a transparent support, especially when it is desirable to isolate the imaging chemistries of the different emulsion layers as disclosed in U.S. Patent No. 5,264,321.

Development conditions will vary, depending on the construction used, but will typically involve heating the imagewise exposed material at a suitably elevated temperature. When used in a photothermographic element, the latent image obtained after exposure of the heat-sensitive element can be developed by heating the material at a moderately elevated temperature of, for example, about 80-250°C, preferably about 100-200°C, for a sufficient period of time, generally about 1 second to about 2 minutes. Heating may be carried out by the typical heating means such as a hot plate, an iron, a hot roller, a heat generator using carbon or titanium white, or the like.

The Support

Photothermographic emulsions used in the invention can be coated on a wide variety of supports. The support, or substrate, can be selected from a wide range of materials depending on the imaging requirement. Supports may be transparent or at least translucent. Typical supports include polyester film, subbed polyester film (e.g., poly(ethylene terephthalate) or polyethylene naphthalate film), cellulose acetate film, cellulose ester film, polyvinyl acetal film, polyolefinic film (e.g., polyethylene or polypropylene or blends thereof), polycarbonate film and related or resinous materials, as well as glass, paper, and the like. Typically, a flexible support is employed, especially a polymeric film support, which can be partially acetylated or coated, particularly with a polymeric subbing or priming agent. Preferred polymeric materials for the support include polymers having good heat stability, such as polyesters. Particularly preferred polyesters are poly(ethylene terephthalate) and poly(ethylene naphthalate).

A support with a backside resistive heating layer can also be used photothermographic imaging systems such as shown in U.S. Patent No. 4,374,921.

25 Use as a Photomask

As noted above, the possibility of low absorbance of the photothermographic element at 380 nm in non-imaged areas facilitates the use of the photothermographic elements of the present invention in a

process where there is a subsequent exposure of an ultraviolet radiation sensitive imageable medium. For example, imaging the photothermographic element with coherent radiation and subsequent development affords a visible image which is free of any visually observable woodgrain pattern. The the developed photothermo-graphic element absorbs ultraviolet radiation in the areas where there is a visible image and transmits ultraviolet radiation where there is no visible image.

The developed element may then be used as a mask and placed between an ultraviolet radiation energy source and an ultraviolet radiation photosensitive imageable medium such as, for example, a photopolymer, diazo material, or photoresist. This process is particularly useful where the imageable medium comprises a printing plate and the photothermographic element serves as an imagesetting film.

Objects and advantages of this invention will now be illustrated by the following examples, but the particular materials and amounts thereof recited in these examples, as well as other conditions and details, should not be construed to unduly limit this invention.

EXAMPLES

All materials used in the following examples were readily available from standard commercial sources such as Aldrich Chemical Co. (Milwaukee, WI) unless

otherwise specified. The following additional terms and materials were used.

Acryloid™ A-21 is an acrylic copolymer available from Rohm and Haas, Philadelphia, PA.

5 Butvar™ B-79 is a polyvinyl butyral resin available from Monsanto Company, St. Louis, MO.

CAB 171-15S is a cellulose acetate butyrate resin available from Eastman Kodak Co.

CBBA is 2-chlorobenzoylbenzoic acid

10 Desmodur™ N3300 is an aliphatic triisocyanate available from Mobay Chemicals, Pittsburgh, PA.

Gelva™ V1.5 is a polyvinyl acetate resin available from Monsanto Company, St. Louis, MO.

MEK is methyl ethyl ketone (2-butanone).

15 MeOH is methanol.

MMBI is 5-methyl-2-mercaptobenzimidazole

4-MPA is 4-methylphthalic acid

Permanax™ WSO is 1,1-bis(2-hydroxy-3,5-dimethyl-phenyl)-3,5,5-trimethylhexane [CAS RN=7292-14-0] and is
20 available from Vulnax International Ltd. It is also known as Nonox.

PE-2200 is a polyester resin available from Shell.

PET is polyethylene terephthalate.

PHP is pyridinium hydrobromide perbromide

25 PHZ is phthalazine

PSMA beads are polystearyl methacrylate beads

SF-200 is Super-Pflex™ 200, a calcium carbonate available from Specialty Minerals, Inc.

TCPA is tetrachlorophthalic acid

TCPAN is tetrachlorophthalic anhydride

THDI is DesmodurTM N-3300, a biuretized hexamethylene diisocyanate available from Mobay.

5 Dmin is the average of eight lowest density values on the exosed side of the fiducial mark.

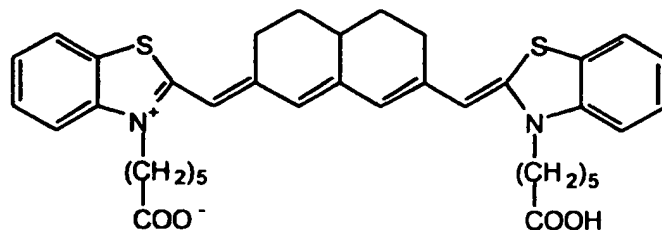
Dhi is the density value corresponding to an exposure at 1.40 Log E greater than the exposure corresponding to 0.20 above Dmin. E is the exposure in ergs/cm².

10 Speed-2 is the Log 1/E + 4 corresponding to a density of 1.00 above Dmin.

AC-1 (Average Contrast 1) is the slope of the line joining the density points 0.60 and 2.00 above Dmin.

15 Dmax is the highest density value on the exposed side of the fiducial mark.

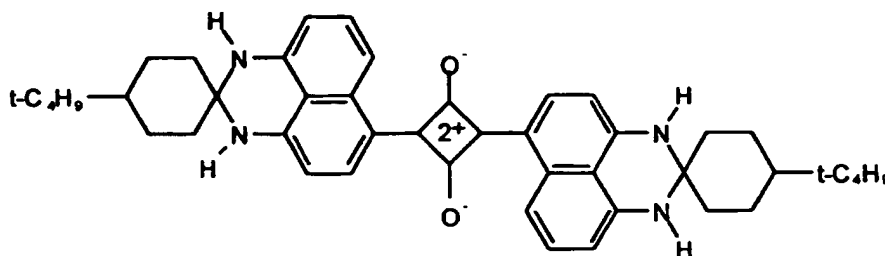
Dye-1 has the structure shown below. Its preparation is disclosed in allowed co-pending U.S. Patent Application USSN 08/202,941 (filed February 28, 1994).



20

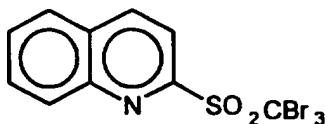
Dye-1

Antihalation Dye-2 has the following structure.
 The preparation of the antihalation Dye-2 is described
 in Example 1f of allowed copending U.S. Patent
 Application USSN 08/203,120 (filed February 28, 1994).

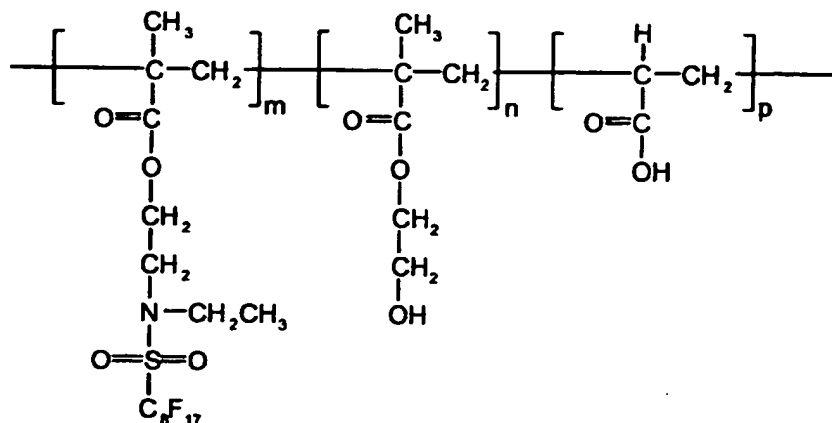


5

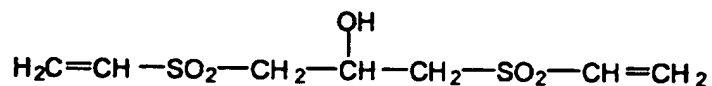
Antifoggant A is 2-(tribromomethylsulfonyl)-
 quinoline has the following structure:



Fluorinated terpolymer A has the following random
 polymer structure, where $m=7$, $n=2$ and $p=1$. The
 preparation of fluorinated terpolymer A is described in
 allowed co-pending U.S. Patent Application USSN
 08/104,888 (filed August 10, 1993).



Vinyl Sulfone is described in European Laid Open Patent Application No. 0 600 589 A2 and has the following structure.



The preparation of an iridium-doped pre-formed core-shell silver iodobromide emulsion, silver soap dispersion, homogenate, and halidized homogenate solutions used in Examples 1-5 are described below.

Preparation of Iridium-Doped Pre-formed Core-Shell Silver Iodobromide Emulsion:

A solution was prepared by mixing the following ingredients while holding the temperature between 30-38°C.

Phthalated gelation	50 g
Deionized Water	1500 mL
Potassium Bromide (0.1 M)	6 mL

The pH of the solution was adjusted to 5.0 with 3N nitric acid. The following aqueous potassium salt and silver nitrate solutions were prepared at 25°C and
5 jetted into the solution described above over 9.5 minutes.

Potassium bromide	27.4 g
Potassium iodide	3.3 g
Deionized water	275.0 g
Silver nitrate	42.5 g
Deionized water	364.0 g

The pAg was held at a constant value by means of a pAg feedback control loop described in Research Disclosure
10 No. 17,643, U.S. Patent Nos. 3,415,650; 3,782,954; and 3,821,002.

The following two aqueous potassium salt and silver nitrate solutions were then jetted into this solution over a 28.5 minutes time interval.

Potassium bromide	179.0 g
Potassium iridium hexachloride	0.010 g
Deionized Water	812.0 g
Silver nitrate	127.0 g
Deionized water	1090.0 g

15 The emulsion was washed with water and then desalted. The average grain size was 0.075 μm (micrometers) as determined by Scanning Electron Microscopy (SEM).

Preparation of Iridium-Doped Pre-formed SilverHalide/Silver Organic Salt Dispersion :

5 A silver halide/silver organic salt dispersion was prepared as described below. This material is also referred to as a silver soap dispersion or emulsion.

Humko Type 9718 fatty acid (available from Witco. Co., Memphis, TN)	118.0 g
Humko type 9022 fatty acid (available from Witco. Co., Memphis, TN)	570.0 g
Sodium Hydroxide (1.4863 m/l)	1.5 L
Nitric acid (19 mL Conc. Nitric acid in 50 mL water)	69 mL
Iridium-doped pre-formed core-shell emulsion (from above) (700 g/mol in 1.25 liters of water)	0.10 mol
Silver Nitrate (0.859 m/L)	2.5 L

10 The fatty acids were dissolved at 80°C in 13 liters of water and mixed for 15 minutes. A dispersion was then formed by the addition of the sodium hydroxide with mixing for 5 minutes. After the addition of the nitric acid solution, the dispersion was cooled to 55°C and stirred for 25 minutes. While maintaining at 55°C the iridium-doped pre-formed core shell emulsion was added and mixed for 5 minutes, followed by the addition of the silver nitrate solution and mixed for an additional 10 minutes. The dispersion was washed with water until the wash water has a resistivity of 20,000 ohm/cm². The dispersion was then dried at 45°C for 72 hours.

Example 1

Example 1 demonstrates the reduction of woodgrain obtained when polymeric beads are incorporated into the topcoat of a photothermographic element.

5

Homogenization of Pre-formed Soaps (Homogenate):

A pre-formed silver fatty acid salt homogenate was prepared by homogenizing the following ingredients:

	<u>Charge</u>	<u>Component</u>	<u>Kg</u>	<u>Wt%</u>
10	A1	MEK	124.00568	78.1102
	A2	Butvar™ B-79	1.74633	1.1000
	A3	Ag Soap*	33.00533	20.7898
15	A	Total Homogenate	158.75734	100.0000

*Iridium-doped pre-formed silver halide/silver organic salt dispersion from above.

The ingredients above were mixed at 21°C for 10 minutes and held for 24 hours. The mixture was homogenized at 4000 psi and then again at 8000 psi.

The following ingredients were sequentially added and mixed to provide a photothermographic silver emulsion coating solution.

25

Photothermographic Silver Emulsion Coating Solution

	<u>Charge</u>	<u>Component</u>	<u>Kg</u>	<u>Wt%</u>
	A	Homogenate	58.57592	64.8103
	B	MEK	3.27730	3.6261
30	C1	PHP	0.08600	0.0952
	C2	MeOH	0.24340	0.2693

	D1	CaBr ₂	0.06559	0.0726
	D2	MeOH	0.37140	0.4109
	E1	MMBI	0.04073	0.0451
	E2	CBBA	0.45187	0.5000
5	E3	Dye-1	0.00835	0.0092
	E4	MeOH	2.93901	3.2518
	F	Butvar™ B-79	14.75010	16.3200
	G1	Antifoggant A	0.34999	0.3872
	G2	MEK	4.02509	4.4535
10	H	Permanax™ WSO	3.02925	3.3517
	I1	THDI	0.17853	0.1975
	I2	MEK	0.08927	0.0988
	J1	TCPA	0.10002	0.1107
	J2	MEK	0.31634	0.3500
15	K1	PHZ	0.30013	0.3321
	K2	MEK	1.18224	1.3081
<hr/>				
	Total Silver Trip Dispersion		90.38053	100.0000

20

The following ingredients were sequentially added and mixed to provide a topcoat solution for coating.

Topcoat 1a - Topcoat Solution Without Beads (Control)

25	<u>Charge</u>	<u>Component</u>	<u>Kg</u>	<u>Wt%</u>
	A	MeOH	3.59979	9.9202
	B	MEK	20.91768	57.6444
	C	TCPAN	0.04129	0.1138
	D	CAB 171-15S	4.31380	11.8879
30	E1	MEK	3.21142	8.8500
	E2	Acryloid™ A-21	0.17451	0.4809

	E3	4-MPA	0.17296	0.4766
	F1	MEK	3.21144	8.8500
	F2	CAB 171-15S	0.22041	0.6074
	F3	SF-200 (CaCO ₃)	0.11020	0.3037
5	G	Fluorinated terpolymer A	0.31392	0.8651

	Total Topcoat Trip Solution	36.28742	100.0000
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10

Topcoat 1b - Topcoat Solution with Beads

	Charge	Component	Kg	Wt%
	A	MeOH	1.00695	9.3701
15	B	MEK	5.85118	54.4476
	C	TCPAN	0.01155	0.1075
	D	CAB 171-15S	1.20667	11.2286
	E1	MEK	0.89831	8.3592
20	E2	Acryloid™ A-21	0.04882	0.4542
	E3	4-MPA	0.04838	0.4502
25	F	Fluorinated terpolymer A	0.08781	0.8171
	G1	MEK	0.22456	2.0896
	G2	CAB 171-15S	0.01027	0.0956
30	G3	2 µm PSMA Beads	0.06298	0.5860

	H1	MEK	0.67373	6.2694
	H2	CAB 171-15S	0.03083	0.2869
5	H3	8 μ m PSMA Beads	0.11468	1.0671
	I1	MEK	0.44918	4.1798
	I2	CAB 171-15S	0.02055	0.1912
10	<hr/>			
	Total Topcoat Trip Solution		10.74645	100.0000

15 The photothermographic silver emulsion coating dispersion and the topcoat solutions were dual coated onto a 7 mil (0.18 mm) unprimed blue tinted polyester support. The coating weight of the photothermographic silver emulsion was 2.20 g/ft² (23.7 g/m²) and the coating weight of the topcoat solutions were 0.24 g/ft² (2.58 g/m²). The coatings were dried for 2-3 minutes at 20 82°C (180°F).

Samples of the coatings of Example 1 were cut into 3.5 cm x 21.5 cm strips. The strips were exposed through a laser sensitometer at 811 nm. The exposed 25 strips were processed for 15 seconds at 255°F (124°C) in a hot roll processor. Sensitometry measurements were made on a custom-built, computer-scanned densitometer and are believed to be comparable to measurements obtainable from commercially available densitometers. 30 Sensitometric results include Dmin, Dmax, Speed, and Contrast.

The haze level of the coating was measured for each sample using a Gardner Haze Meter XL-211 Model 8011.

5 Example 1C is the control and Example 1 is the sample of this invention. The following results were obtained:

Ex.	%Haze	Dmin	Dhi	Speed-3	AC-1	Dmax
1C	17.4	0.22	3.91	1.76	4.53	3.96
10 1	21.8	0.22	3.93	1.69	4.39	4.02

15 The presence and severity of woodgrain was determined by preparing "greyouts." Greyouts are samples that have been uniformly exposed to light and developed so that the samples have a uniform Optical Density, for example between 1.0 and 2.0. They visually appear to have a uniform grey appearance.

20 Greyouts were prepared using a laser diode emitting at 811 nm with a power of 150 mWatt. Image information was digitized and converted into signal that modulated a laser beam to expose the photothermographic element to achieve a uniform optical density of about 1.8. Scanning was accomplished by a galvanometer or a scanning mirror. The sample remained stationary
25 and the laser scanned across the sample with an overlapping raster pattern. After scanning, the samples were developed at 255°F (124°C) for 15 seconds by heating on a rotating drum thermal processor.

Greyouts effected by laser exposure were compared with greyouts obtained by uniformly exposing identical samples to a white incandescent light source that also emitted in the infrared. This latter type of exposure is also referred to as a "floodlight" exposure or a "blanket" exposure. Again, exposure conditions were adjusted so that greyouts had a uniform Optical Density of about 1.8.

The amount of woodgrain present was subjectively determined by comparing samples placed on a X-ray view box. Woodgrain was rated as high, medium, or low.

<u>Sample</u>	<u>Exposure Method</u>	<u>Woodgrain</u>
<u>Rating</u>		
With Beads	Scanning Laser	Low Woodgrain
No Beads (Control)	Scanning Laser	High Woodgrain
With Beads	Blanket Exposure	No Woodgrain
Control No Beads	Blanket Exposure	No Woodgrain

Example 2

Example 2 demonstrates the reduction of woodgrain obtained when the support is coated with a polyester primer coating in an attempt to provide a graded transition between the refractive index of the support to the refractive index of the emulsion layer.

Homogenization of Pre-formed Soaps (Homogenate):

A pre-formed silver fatty acid salt homogenate was prepared by homogenizing the following ingredients:

	<u>Charge</u>	<u>Component</u>	<u>Kg</u>	<u>Wt%</u>
	A1	MEK	99.86743	78.1103
	A2	Butvar™ B-79	1.40640	1.1000
5	A3	Ag Soap*	26.58051	20.7897
	A	Total Homogenate	127.85434	100.0000

*Iridium-doped pre-formed silver halide/silver organic salt dispersion from above.

10

The ingredients above were mixed at 21°C for 10 minutes and held for 24 hours. The mixture was homogenized at 4000 psi and then again at 8000 psi.

The following ingredients were sequentially added and mixed to provide a photothermographic silver emulsion coating solution.

Photothermographic Silver Emulsion Coating Solution

	<u>Charge</u>	<u>Component</u>	<u>Kg</u>	<u>Wt%</u>
20	A	Homogenate	85.84068	63.0529
	B	MEK	4.17609	3.0675
	C1	PHP	0.12600	0.0926
25	C2	MeOH	0.35667	0.2620
	D1	CaBr ₂	0.09606	0.0706
	D2	MeOH	0.54432	0.3998

	E1	MMBI	0.05973	0.0439
	E2	CBBA	0.66216	0.4864
5	E3	Dye-1	0.01224	0.0090
	E4	MeOH	4.30698	3.1636
	F	Butvar™ B-79	21.45224	15.7574
10	G1	Antifoggant A	0.51288	0.3767
	G2	MEK	5.89857	4.3327
15	H	Permanax™ WSO	4.93254	3.6231
	I1	THDI	0.26166	0.1922
	I2	MEK	0.13077	0.0961
	J1	TCPA	0.16290	0.1197
	J2	MEK	0.46362	0.3405
20	K1	PHZ	0.48867	0.3589
	K2	MEK	1.73253	1.2726
	L1	Butvar™ B-79	0.16343	0.1200
	L2	PE2200	1.12799	0.8285
25	L3	MEK	2.631972	1.9333
Total Silver Trip Dispersion			136.14070	100.0000

30 The following ingredients were sequentially added
and mixed to provide a topcoat solution for coating.

Topcoat 2 - Topcoat Solution

	Charge	Component	Kg	Wt%
	A	MeOH	13.48666	9.9110
	B	MEK	78.26115	57.5123
5	C	Vinyl Sulfone	0.22930	0.1685
	D	CAB 171-15S	16.19325	11.9000
	E	Fluorinated terpolymer A	1.17639	0.8645
	F1	MEK	12.11309	8.9016
10	F2	Acryloid™ A-21	0.65393	0.4806
	F3	4-MPA	0.63817	0.4690
	G1	MEK	12.11309	8.9016
	G2	CAB 171-15S	0.79864	0.5869
	G3	SF-200 (CaCO ₃)	0.41357	0.3039
15	Total Topcoat Trip Solution		136.07724	100.0000

The following ingredients were sequentially added
and mixed to provide a primer solution for the support.

20

Primer Solution - PE-2200

	Charge	Component	Kg	Wt%
	A	MEK	30.00000	58.6667
	B	PE2200	4.09091	8.0000
25	C	Toluene	17.04545	33.3333
	Total Primer Layer Solution		51.13636	100.0000

One sample of a 7 mil (0.18 mm) unprimed blue
tinted polyester support was coated with the PE-2200

30

polyester primer solution at a coating weight of
0.18 g/ft² (1.94 g/m²). A second sample remained
unprimed. The photothermographic emulsion silver trip
dispersion and the topcoat solutions were dual coated
5 onto the primed and unprimed supports. The coating
weight of the photothermographic silver emulsion was
2.20 g/ft² (23.7 g/m²) and the coating weight of the
topcoat solution was 0.24 g/ft² (2.58 g/m²). The
coatings were dried for 2-3 minutes at 82°C (180°F).

10 Example 2C is the control and Example 2 is the sample
of this invention.

Sensitometry of the samples were evaluated as
described in Example 1 above. The following results
were obtained:

15

Ex.	Dmin	Dhi	Speed-3	AC-1	Dmax
2C	0.30	3.63	1.94	4.34	3.80
2	0.30	3.77	1.88	4.31	3.92

20 The presence and severity of woodgrain were
determined by preparing "greyouts" as described in
Example 1 above. Again, exposure conditions were
adjusted so that greyouts had a uniform Optical Density
of about 1.8.

25 The amount of woodgrain present was subjectively
determined by comparing samples placed on a X-ray view
box. Woodgrain was rated as high, medium, or low.

	<u>Sample</u>	<u>Exposure Method</u>	<u>Woodgrain</u>
	<u>Rating</u>		
	With Primer	Scanning Laser	Low Woodgrain
	No Primer (Control)	Scanning Laser	High Woodgrain
5	With Primer	Blanket Exposure	No Woodgrain
	Control No Primer	Blanket Exposure	No Woodgrain

Example 3

Example 3 demonstrates the reduction of woodgrain obtained when a support is coated with a primer layer also containing particles such as polymeric beads. Again, this is an experiment to provide a graded transition between the refractive index of the support and the refractive index of the emulsion layer along with particles capable of providing diffuse reflection.

Homogenization of Pre-formed Soaps (Homogenate):

A pre-formed silver fatty acid salt homogenate was prepared by homogenizing the following ingredients:

20

25

<u>Charge</u>	<u>Component</u>	<u>Kg</u>	<u>Wt%</u>
A1	MEK	124.00568	78.1102
A2	Butvar™ B-79	1.74633	1.1000
A3	Ag Soap*	33.00533	20.7898
A	Total Homogenate	100.000	100.0000

*Iridium-doped pre-formed silver halide/silver organic salt dispersion from above.

The ingredients above were mixed at 21°C for 10 minutes and held for 24 hours. The mixture was homogenized at 4000 psi and then again at 8000 psi.

5 The following ingredients were sequentially added and mixed to provide a photothermographic silver emulsion coating solution.

Photothermographic Silver Emulsion Coating Solution

	<u>Charge</u>	<u>Component</u>	<u>Kg</u>	<u>Wt%</u>
10	A	Homogenate	85.84068	63.0529
	B	MEK	4.17609	3.0675
	C1	PHP	0.12600	0.0926
15	C2	MeOH	0.35667	0.2620
	D1	CaBr ₂	0.09606	0.0706
	D2	MeOH	0.54432	0.3998
	E1	MMBI	0.05973	0.0439
20	E2	CBBA	0.66216	0.4864
	E3	Dye-1	0.01224	0.0090
25	E4	MeOH	4.30698	3.1636
	F	Butvar™ B-79	21.45224	15.7574

	G1	Antifoggant A	0.51288	0.3767
	G2	MEK	5.89857	4.3327
5	H	Permanax™ WSO	4.93254	3.6231
	I1	THDI	0.26166	0.1922
	I2	MEK	0.13077	0.0961
	J1	TCPA	0.16290	0.1197
	J2	MEK	0.46362	0.3405
10	K1	PHZ	0.48867	0.3589
	K2	MEK	1.73253	1.2726
	L1	Butvar™ B-79	0.16343	0.1200
	L2	PE2200	1.12799	0.8285
15	L3	MEK	2.631972	1.9333
Total Silver Trip Dispersion			136.14070	100.0000

20 The following ingredients were sequentially added
and mixed to provide a topcoat solution for coating.

Topcoat 2 - Topcoat Solution

	Charge	Component	Kg	Wt%
	A	MeOH	13.48666	9.9110
25	B	MEK	78.26115	57.5123
	C	Vinyl Sulfone	0.22930	0.1685
	D	CAB 171-15S	16.19325	11.9000
	E	Fluorinated terpolymer A	1.17639	0.8645
	F1	MEK	12.11309	8.9016
30	F2	Acryloid™ A-21	0.65393	0.4806
	F3	4-MPA	0.63817	0.4690

	G1	MEK	12.11309	8.9016
	G2	CAB 171-15S	0.79864	0.5869
	G3	SF-200 (CaCO ₃)	0.41357	0.3039
5	Total Topcoat Trip Solution		136.07724	100.0000

The following ingredients were sequentially added and mixed to provide a primer solution for the support.

10 **Primer Solution - PE-2200 + Polymeric Beads**

	Charge	Component	Kg	Wt%
	A	MEK	10.00000	58.4334
	B	PE2200	1.36364	7.9682
	C	Toluene	5.68182	33.2008
15	D	PSMA-8 (8 μ m beads)	0.06804	0.3976
	Total Primer Layer Solution		17.11349	100.0000

20 One sample of a 7 mil (0.18 mm) unprimed blue tinted polyester support was coated with the PE-2200 polyester primer solution containing 8 μ m PSMA-8 beads at a coating weight of 0.18 g/ft² (1.94 g/m²). A second sample remained unprimed. The photothermographic silver emulsion coating dispersion and the topcoat solutions were dual coated onto the primed and unprimed supports. The coating weight of the photothermographic silver emulsion was 2.20 g/ft² (23.7 g/m²) and the coating weight of the topcoat solutions were 0.24 g/ft² (2.58 g/m²). The coatings were dried for 2-3 minutes at

82°C (180°F). Example 3C is the control and Example 3 is the sample of this invention.

Sensitometry of the samples were evaluated as described in Example 1 above. The following results were obtained:

<u>Ex.</u>	<u>Dmin</u>	<u>Dhi</u>	<u>Speed-3</u>	<u>AC-1</u>	<u>Dmax</u>
3C	0.30	3.63	1.94	4.34	3.80
3	0.30	3.74	1.88	3.27	3.87

The presence and severity of woodgrain were determined by preparing "greyouts" as described above in Example 1. Again, exposure conditions were adjusted so that greyouts had a uniform Optical Density of about 1.8.

The amount of woodgrain present was subjectively determined by comparing samples placed on a X-ray view box. Woodgrain was rated as high, medium, or low.

<u>Sample</u>	<u>Exposure Method</u>	<u>Woodgrain Rating</u>
With Primer + Beads	Scanning Laser	Low Woodgrain
No Primer (Control)	Scanning Laser	High Woodgrain
With Primer + Beads	Blanket Exposure	No Woodgrain
Control No Primer	Blanket Exposure	No Woodgrain

Example 4

Example 4 demonstrates the woodgrain reduction when an Acutance Dye is contained in the topcoat layer of the photothermographic element. It has been determined that the acutance dye migrates into the emulsion layer during coating and drying.

Homogenization of Pre-formed Soaps (Homogenate):

A pre-formed silver fatty acid salt homogenate was prepared by homogenizing the following ingredients:

<u>Charge</u>	<u>Component</u>	<u>Kg</u>	<u>Wt%</u>
A1	MEK	124.00568	78.1102
A2	Butvar™ B-79	1.74633	1.1000
A3	Ag Soap*	33.00533	20.7898
A	Total Homogenate	158.75734	100.0000

*Iridium-doped pre-formed silver halide/silver organic salt dispersion from above.

The ingredients above were mixed at 21°C for 10 minutes and held for 24 hours. The mixture was homogenized at 4000 psi and then again at 8000 psi.

The following ingredients were sequentially added and mixed to provide a photothermographic silver emulsion coating solution.

Photothermographic Silver Emulsion Coating Solution

	Charge	Component	Kg	Wt%
	A	Homogenate	65.89785	64.5383
	B	MEK	3.68696	3.6109
5	C1	PHP	0.09674	0.0947
	C2	MeOH	0.27380	0.2682
	D1	CaBr ₂	0.07375	0.0722
	D2	MeOH	0.41785	0.4092
	E1	MMBI	0.04586	0.0449
10	E2	CBBA	0.50832	0.4978
	E3	Dye-1	0.00940	0.0092
	E4	MeOH	3.30638	3.2382
	F	Butvar™ B-79	16.59384	16.2515
	G1	Antifoggant-A	0.39372	0.3856
15	G2	MEK	4.52819	4.4348
	H	Permanax™ WSO	3.78660	3.7085
	I1	THDI	0.20088	0.1967
	I2	MEK	0.10039	0.0983
	J1	TCPA	0.12504	0.1225
20	J2	MEK	0.35591	0.3486
	K1	PHZ	0.37513	0.3674
	K2	MEK	1.33003	1.3026
	Total Silver Trip Dispersion		102.10664	100.0000

25

The following ingredients were sequentially added and mixed to provide a topcoat solution for coating.

Topcoat - Topcoat Solution

	<u>Charge</u>	<u>Component</u>	<u>Kg</u>	<u>Wt%</u>
	A	MeOH	13.48666	9.9110
	B	MEK	78.26115	57.5123
5	C	Vinyl Sulfone	0.22930	0.1685
	D	CAB 171-15S	16.19325	11.9000
	E	Fluorinated terpolymer A	1.17639	0.8645
	F1	MEK	12.11309	8.9016
10	F2	Acryloid™ A-21	0.65393	0.4806
	F3	4-MPA	0.63817	0.4690
	G1	MEK	12.11309	8.9016
	G2	CAB 171-15S	0.79864	0.5869
	G3	SF-200 (CaCO ₃)	0.41357	0.3039
15	Total Topcoat Trip Solution		136.07724	100.0000

A topcoat solution containing acutance Dye-2 was prepared by sequentially adding and mixing the ingredients shown below.

Topcoat - Topcoat Solution Containing Acutance Dye

	<u>Charge</u>	<u>Component</u>	<u>Kg</u>	<u>Wt%</u>
25	A	Topcoat Trip Solution from above	9.07185	93.5257
	B	MeOH	0.60000	6.1857
	C	Dye-2	0.02800	0.2887
	Total Topcoat Trip Solution		9.69985	100.0000

One photothermographic element was prepared by dual coating 7 mil (0.18 mm) unprimed blue tinted polyester support with the photothermographic silver emulsion coating dispersion and topcoat solution containing no acutance dye. Another photothermographic element was prepared by dual coating 7 mil (0.18 mm) unprimed blue tinted polyester support with the photothermographic silver emulsion coating dispersion and topcoat solution containing acutance Dye-2. The coating weight of the photothermographic silver emulsion was 2.20 g/ft² (23.7 g/m²) and the coating weight of the topcoat solutions were 0.24 g/ft² (2.58 g/m²). The coatings were dried for 2-3 minutes at 82°C (180°F). Example 4C is the control and Example 4 is the sample of this invention.

Sensitometry of the samples were evaluated as described in Example 1 above. The following results were obtained:

Ex.	Dmin	Dhi	Speed-3	AC-1	Dmax
4C	0.23	3.94	1.85	4.78	4.07
4	0.40	----	1.32	3.73	3.55

The presence and severity of woodgrain were determined by preparing "greyouts" as described in Example 1. Again, exposure conditions were adjusted so that greyouts had a uniform Optical Density of about 1.8.

The amount of woodgrain present was subjectively determined by comparing samples placed on a X-ray view box. Woodgrain was rated as high, medium, or low.

5	<u>Sample</u>	<u>Exposure Method</u>	<u>Woodgrain</u>
	<u>Rating</u>		
	With Acutance Dye	Scanning Laser	Low Woodgrain
	Control (No Dye)	Scanning Laser	High Woodgrain
	With Acutance Dye	Blanket Exposure	No Woodgrain
10	Control (No Dye)	Blanket Exposure	No Woodgrain

Example 5

Example 5 demonstrates the woodgrain reduction when a polyester resin is used in the emulsion layer of the photothermographic element. The polyester resin used was Shell PE-2200.

Homogenization of Pre-formed Soaps (Homogenate):

A pre-formed silver fatty acid salt homogenate was prepared by homogenizing the following ingredients:

<u>Charge</u>	<u>Component</u>	<u>Kg</u>	<u>Wt%</u>
A1	MEK	122.24791	
	77.0030		
25	A2 Butvar™ B-79	3.50409	
	2.2072		
A3	Ag Soap*	33.00533	
	20.7898		

A Total Homogenate 158.7573
100.0000

Iridium-doped pre-formed silver halide/silver organic salt
dispersion from above.

5

The ingredients above were mixed at 21°C for 10 minutes
and held for 24 hours. The mixture was homogenized at
4000 psi and then again at 8000 psi.

The following ingredients were sequentially added
and mixed to provide a photothermographic silver
emulsion coating dispersion.

Photothermographic Silver Emulsion Coating Dispersion

	Charge	Component	Kg	Wt%
15	A	Homogenate	28.78225	
		63.4540		
	B	MEK	2.84861	
		6.2801		
	C1	PHP	0.02087	
20		0.0460		
	C2	MeOH	0.11825	0.2607
	D1	CaBr ₂	0.03184	0.0702
	D2	MeOH	0.18048	0.3979
	E1	MMBI	0.01978	0.0436
25	E2	CBBA	0.21954	0.4840
	E3	Dye-1	0.00408	0.0090
	E4	MeOH	1.43902	3.1725
	F	Butvar™ B-79	6.84435	15.0892
	G1	Antifoggant 1	0.17005	0.3749
30	G2	MEK	1.95566	4.3115
	H	Permanax™ WSO	1.63538	3.6054

5	I1	THDI	0.09657	0.2129
	I2	MEK	0.04831	0.1065
	J1	TCPA	0.05402	0.1191
	J2	MEK	0.15372	0.3389
	K1	PHZ	0.16202	0.3572
	K2	MEK	0.57443	1.2664
Total Silver Trip Dispersion			45.35923	100.0000

10 The following ingredients were sequentially added and mixed to provide a topcoat solution for coating.

Topcoat Solution

	Charge	Component	Kg	Wt%
15	A	MeOH	13.57770	9.9826
	B	MEK	78.83349	57.9602
	C	TCPAN	0.14968	0.1100
	D	CAB 171-15S	15.63165	11.4927
20	E	Fluorinated terpolymer A	1.13747	0.8363
	F1	MEK	12.11309	8.9058
	F2	Acryloid™ A-21	0.63235	0.4649
	F3	4-MPA	0.62664	0.4607
	G1	MEK	12.11309	8.9058
25	G2	CAB 171-15S	0.79864	0.5872
	G3	SF-200 CaCO ₃	0.39939	0.2936
Topcoat Trip Solution			136.01319	100.0000

30 The following ingredients were sequentially added and mixed to provide a photothermographic silver

emulsion coating dispersion containing a polyester resin in the emulsion layer of the photothermographic element.

5 **Photothermographic Silver Emulsion Coating Dispersion**

	<u>Charge</u>	<u>Component</u>	<u>Kg</u>	<u>Wt%</u>
	A	Homogenate	28.78225	60.5990
	B	MEK	2.84861	5.9975
	C1	PHP	0.02087	0.0439
10	C2	MeOH	0.11825	0.2490
	D1	CaBr ₂	0.03184	0.0670
	D2	MeOH	0.18048	0.3800
	E1	MMBI	0.01978	0.0416
	E2	CBBA	0.21954	0.4622
15	E3	Dye-1	0.00408	0.0086
	E4	MeOH	1.43902	3.0298
	F	Butvar™ B-79	6.84435	14.4103
	G1	Antifoggant A	0.17005	0.3580
	G2	MEK	1.95566	4.1175
20	H	Permanax™ WSO	1.63538	3.4432
	I1	THDI	0.09657	0.2033
	I2	MEK	0.04831	0.1017
	J1	TCPA	0.05402	0.1137
	J2	MEK	0.15372	0.3236
25	K1	PHZ	0.16202	0.3411
	K2	MEK	0.57443	1.2094
	L1	PE-2200	0.74797	1.5748
	L2	MEK	1.38908	2.9246
30	Total Silver Trip Dispersion		47.49628	100.0000

The following ingredients were sequentially added and mixed to provide a topcoat solution for coating.

Topcoat Solution

Charge	Component	Kg	Wt%
A	MeOH	13.57770	9.9826
B	MEK	78.83349	57.9602
C	TCPAN	0.14968	0.1100
D	CAB 171-15S	15.63165	11.4927
E	Fluorinated terpolymer A	1.13747	0.8363
F1	MEK	12.11309	8.9058
F2	Acryloid™ A-21	0.63235	0.4649
F3	4-MPA	0.62664	0.4607
G1	MEK	12.11309	8.9058
G2	CAB 171-15S	0.79864	0.5872
G3	SF-200 CaCO ₃	0.39939	0.2936
Topcoat Trip Solution		136.01319	100.0000

One photothermographic element was prepared by dual coating 7 mil (0.18 mm) unprimed blue tinted polyester support with the photothermographic silver emulsion coating dispersion containing no polyester resin in the emulsion layer and topcoat solution. Another photothermographic element was prepared by dual coating 7 mil (0.18 mm) unprimed blue tinted polyester support with the photothermographic silver emulsion coating dispersion containing PE-2200 polyester resin and topcoat solution. The coating weight of the

photothermographic silver emulsion was 2.20 g/ft² (23.7 g/m²) and the coating weight of the topcoat solutions were 0.24 g/ft² (2.58 g/m²). The coatings were dried for 2-3 minutes at 82°C (180°F). Example 5C is the control and Example 5 is the sample of this invention.

Sensitometry of the samples and haze were evaluated as described in Example 1 above. The following results were obtained:

Ex.	%Haze	Dmin	Dhi	Speed-3	AC-1	Dmax
5C	15.5	0.22	3.89	1.73	4.43	4.12
5	22.9	0.22	3.64	1.60	4.22	3.79

The presence and severity of woodgrain were determined by preparing "greyouts" as described in Example 1. Again, exposure conditions were adjusted so that greyouts had a uniform Optical Density of about 1.8.

The amount of woodgrain present was subjectively determined by comparing samples placed on a X-ray view box. Woodgrain was rated as high, medium, or low.

Sample	Exposure Method	Woodgrain
Rating		
With PE-2200 Resin	Scanning Laser	Low Woodgrain
Control (No Resin)	Scanning Laser	High Woodgrain
With PE-2200 Resin	Blanket Exposure	No Woodgrain
Control (No Resin)	Blanket Exposure	No Woodgrain

Reasonable modifications and variations are possible from the foregoing disclosure without departing from either the spirit or scope of the present invention as defined by the claims.

What is claimed is:

1. A spectrally sensitized photothermographic silver halide element comprising a transparent organic polymeric support layer having on at least one surface thereof a photothermographic composition layer which displays uniform image density across its surface when exposed to floodlight or uniform incandescent light exposure at a wavelength of radiation to which the composition is sensitive, said composition layer comprising at least two layers, including a top layer and a photothermographic emulsion layer, said layer comprising a binder, a light insensitive silver source, a reducing agent for silver ion and radiation sensitive silver halide grains, wherein 1) the top layer of the element has haze induced therein of 0.05 to 30%, 2) there is a random refractive pattern on the top layer, 3) there is haze in the silver halide containing layer caused by particulates, 4) the reflective characteristics of a surface of the support layer facing the photothermographic composition have been altered to reduce reflection of coherent radiation into said composition, and/or 5) said element having dyes

therein which absorb said radiation to which said composition is sensitive.

2. The element of claim 1 wherein said silver halide grains are pre-formed silver halide grains which have a number average particle size of $<0.10\ \mu\text{m}$ with at least 80% of all grains with $\pm 0.05\ \mu\text{m}$ of the average.
3. The element of claim 1 wherein said haze in said top layer is provided by the presence of particles in said top layer, said particles having a number average size of 0.5 to $12\ \mu\text{m}$.
4. The element of Claim 1, which without exposure and after thermal development for thirty seconds at 140°C has an optical density at $380\ \text{nm}$ of less than 0.1 .
5. A spectrally sensitized photothermographic silver halide element comprising a support layer having on at least one surface thereof a photothermographic emulsion layer which displays uniform image density across its surface when exposed to floodlight or uniform incandescent light exposure at a wavelength of radiation to which the composition is sensitive, and said element displaying less than 0.05 variation in average optical density amongst any three linearly consecutive areas defined by squares of from $0.5\ \text{mm}^2$ to $5\ \text{cm}^2$ when said element is uniformly exposed over its entire surface to coherent radiation to which said

element is spectrally sensitive, said photothermo-
graphic element including a top layer and said photo-
thermographic emulsion layer comprising a binder, a
light insensitive silver source, a reducing agent for
5 silver ion, and radiation sensitive silver halide
grains.

6. The element of claim 5 wherein said three linearly
consecutive areas are squares of 1mm^2 .

10 7. The element of claim 6 wherein said top layer
displays a first spatial frequency of variations in a
first property which alters light refraction and light
reflection, said first property being selected from the
15 group consisting of surface planarity and thickness,
and said element having at least one second property
which alters light refraction and light reflection
provided by at least one of said photothermographic
emulsion layer, said top layer, and said support layer,
20 said second property being a second spatial frequency
of variations which is a frequency at least two times
higher than said first spatial frequency, said second
property being provided at least in part by at least
one feature selected from the group consisting of a)
25 the inclusion of particulates other than silver salts
of organic acids, b) acutance dyes in said
photothermographic emulsion layer, c) haze in said
photothermographic element, and d) a primer layer on
said support layer which has an index of refraction

intermediate the index of refraction of said support layer and said photothermographic emulsion layer.

8. A process for the exposure of an imageable element comprising the steps of:

- a) exposing the element of claim 1 to coherent radiation to which said silver halide grains are sensitive to generate a latent image,
- b) heating said element after exposure to develop said latent image to a visible image which is free of any visually observable woodgrain pattern.

9. The element of claim 1 wherein haze is provided in said topcoat by the presence of particulates in said topcoat and said haze in said topcoat has a value between 0.5 and 10%.

10. A spectrally sensitized photothermographic silver halide element comprising a support layer having on at least one surface thereof a photothermographic emulsion layer which displays uniform image density across its surface when exposed to floodlight or uniform incandescent light exposure at a wavelength of radiation to which the composition is sensitive, and said element displaying less than 0.05 variation in average optical density between adjacent areas of 1 mm² when said element is uniformly exposed over its entire surface to coherent radiation to which said element is

spectrally sensitive, said photothermographic element including a top layer and said photothermographic emulsion layer comprising a binder, a light insensitive silver source, a reducing agent for silver ion, and radiation sensitive silver halide grains.

11. The element of claim 10 wherein said element is spectrally sensitized to the infrared region of the electromagnetic spectrum, and said element has at least one feature selected from:

a) said top layer having a random refractive pattern in its surface;

b) said top layer containing particles which diffuse coherent radiation striking the surface of the element;

c) said element further comprising a support layer and a surface of said support layer facing said photothermographic layer has a surface which does not uniformly reflect coherent radiation off said surface;

d) said element further comprising a support and a surface of said support facing said photothermographic layer has polymeric particles on said surface; and

e) wherein said element further comprising a support and a surface of said support facing said photothermographic layer has a primer layer thereon which has an index of refraction intermediate the index of refraction of said support and the index of refraction of said photothermographic layer.

12. A spectrally sensitized photothermographic silver halide element comprising a support layer having on at least one surface thereof a photothermographic emulsion layer which displays uniform image density across its surface of less than 0.05 variation in average optical density between linearly adjacent areas in the form of squares of 1 cm² when exposed to floodlight or uniform incandescent light exposure at a wavelength of radiation to which the composition is sensitive, said photothermographic element including a top layer and said photothermographic emulsion layer comprising a binder, a light insensitive silver source, a reducing agent for silver ion, and radiation sensitive silver halide grains, said top layer having a variation in a property selected from the group consisting of thickness and surface smoothness which has a first spatial frequency, and said element having at least one additional feature which has a second spatial frequency which is higher than said first spatial frequency, said additional feature being selected from the group consisting of 1) physical structure on any surface of said photothermographic emulsion layer or said top layer, and physical structure on a face of said support layer facing said photothermographic emulsion layer which physical structure alters the refraction and/or reflection characteristics of radiation passing through said surface and 2) haze within a layer between the

surface of the top layer and a surface of the support layer facing said photothermographic emulsion layer.

INTERNATIONAL SEARCH REPORT

International Application No

PCT/US 95/13073

A. CLASSIFICATION OF SUBJECT MATTER
IPC 6 G03C1/498

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
IPC 6 G03C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US,A,4 711 838 (GRZESKOWIAK ET AL.) 8 December 1987 cited in the application see column 4, line 20 - column 7, line 32 see column 9, line 4 - line 6 ---	1-12
A	FR,A,2 075 076 (KODAK) 8 October 1971 see page 2, line 27 - line 32; claims 1,4,5 ---	1-12
P,A	EP,A,0 627 660 (3M) 7 December 1994 see page 3, line 43 - page 4, line 1 see claims 1-10 -----	1-12

☐ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

* Special categories of cited documents:

- "A" document defining the general state of the art which is not considered to be of particular relevance
- "E" earlier document but published on or after the international filing date
- "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- "O" document referring to an oral disclosure, use, exhibition or other means
- "P" document published prior to the international filing date but later than the priority date claimed

- "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
- "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
- "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.
- "&" document member of the same patent family

Date of the actual completion of the international search

16 February 1996

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INTERNATIONAL SEARCH REPORT

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		CA-A- 971811	29-07-75
		DE-A- 2063645	08-07-71
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		US-A- 3608059	11-05-71
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		DE-A- 2063647	15-07-71
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EP-A-627660	07-12-94	JP-A- 7013295	17-01-95